### Technical Data Sheet BrazeTec D 5600.1

#### Standard
- ISO 17672
- (DIN EN 1044)
- DIN EN 1045

#### Nominal composition [wt.-%]
- Ag 56; Cu 22; Zn 17; Sn 5

#### Permitted impurities max. [wt.-%]
- Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05

#### Max. impurities [wt.-%]
- 0.15

#### Technical data
- **Melting range of brazing alloy**: approx. 620 - 655 °C
- **Working temperature**: approx. 65 °C
- **Density of brazing alloy**: approx. 9.5 g/cm³
- **Density of brazing paste**: approx. 2.8 g/cm³ (20 °C)
- **Metal content**: approx. 65 wt.-%
- **Grain size of brazing alloy powder**: < 106 µm
- **Viscosity**: 1100 - 1300 dPa s (Haake Viscotester 02; Sp. 2; 20 ±2 °C)
- **Residues**: corrosive, soluble in water
- **Tensile strength acc. DIN EN 12797**: with S235: 350 MPa; with S550: 430 MPa
- **Operating temperature of joint**: max. 200 °C (without loss of strength)
- **Cleaning agent**: BrazeTec Cleaning Agent P
- **Shelf life**: Can / bucket: min. 6 months in the original closed container.
  - Storage temperature +5 to +30 °C.
  - Stir cans and buckets well before use.

#### Packaging
- **Standard**: 0.075; 1; 3; 5; 10 kg

#### Applications
BrazeTec D 5600.1 is a dosable brazing paste for use with brazing machines. It contains flux and a low melting free flowing silver brazing alloy.

The paste is suitable for brazing copper and copper alloys, nickel and nickel alloys as well as steels. BrazeTec D 5600.1 is suitable for all common brazing methods, like torch brazing, furnace brazing and induction brazing.

Typical applications are found e.g. in the sanitary, electric and automotive industry.

#### Further comments:
- Paste residues are corrosive and have therefore to be removed carefully.

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