

Technical Data Sheet BrazeTec D 810.6

Standard

ISO 17672
(DIN EN 1044)

CuP 182
(CP 201)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]
Max. impurities [wt.-%]

Cu Rem.; P 7.8
Al 0.01; Bi 0.03; Cd 0.01; Pb 0.025; Zn 0.050; Zn + Cd 0.050;
0.25

Technical data

Melting range of brazing alloy	approx. 710 - 770 °C
Recommended brazing temperature	approx. 750 °C
Density of brazing alloy	approx. 8.0 g/cm ³
Density of brazing paste	approx. 4.2 g/cm ³ (20 °C)
Metal content	approx. 92 wt.-%
Grain size of brazing alloy powder	< 71 µm
Viscosity	540 - 620 Pa s (Brookfield RVT, Sp. E, 2,5 rpm; 20 ± 1 °C)
Flash point of solvent	approx. 73 °C
Evaporation temperature of binder	approx. 180 - 420 °C at 1 bar
Tensile strength acc. DIN EN 12797	with Cu: 250 MPa
Operating temperature of joint	max. 150 °C (without loss of strength)
Cleaning agent	BrazeTec Cleaning Agent TD
Shelf life	min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C.

Packaging

Standard 1; 3; 20 kg

Applications

BrazeTec D 810.6 is a dosable brazing paste with a high metal content. This dosable paste can be applied by air pressure or screw dispenser techniques.

BrazeTec D 810.6 can be used for brazing of copper to copper in protective atmospheres.

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