### Technical Data Sheet BrazeTec D 810.6

<table>
<thead>
<tr>
<th>Standard</th>
<th>ISO 17672 (DIN EN 1044)</th>
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<tbody>
<tr>
<td>Nominal composition [wt.-%]</td>
<td>Cu Rem.; P 7.8</td>
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<tr>
<td>Permitted impurities max. [wt.-%]</td>
<td>Al 0.01; Bi 0.03; Cd 0.01; Pb 0.025; Zn 0.050; Zn + Cd 0.050; 0.25</td>
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#### 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/cm³
- **Density of brazing paste**: approx. 4.2 g/cm³ (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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