

Technical Data Sheet BrazeTec Soldamoll 220

Standard

Alloy-No. acc. ISO 9453 703
(ISO 3677) (Sn96.5Ag3.5)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%] Sn remainder; Ag 3.5
Pb 0.10; Sb 0.10; Bi 0.10; Cu 0.05; Au 0.05; In 0.10;
Al 0.001; As 0.03; Cd 0.002; Fe 0.02; Ni 0.01; Zn 0.001

Technical data

Melting range approx. 221 °C
Density approx. 7,3 g/cm³
Shear strength acc. DIN EN 12797 with S235: 25 MPa; with Cu 30 MPa; with Ms 20 MPa
Electrical Conductivity approx. 7,5 m/Ωmm²

Standard delivery forms*

Wire: 0,8 - 4,0 mm Ø
Rods: 1,5 - 2,0 - 3,0 mm Ø, 500 mm length
Ribbon: 0,1/ 0,2/ 0,3/ 0,4 mm thickness and 40 mm width

*Other delivery forms upon request

Applications

BrazeTec Soldamoll 220 is a soft solder free of Antimony and Lead with excellent flow characteristics. It can be used for brazing any steels, copper and copper based alloys as well as for nickel and nickel based alloys.

It can be used for soldering with a flame, with induction heating, with resistance heating and with soldering iron.

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

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