

Technical Data Sheet BrazeTec S 6

Standard ISO 17672	CuP 283
Nominal composition [wt.-%] Permitted impurities max. [wt.-%] Max. impurities [wt.-%]	Cu remainder; Ag 6; P 7 Al 0,01; Bi 0,030; Cd <0,01; Pb 0,025; Zn 0,05; Zn + Cd 0,05 0,25
Technical data Melting range acc. ISO 17672 Working temperature Density Operating temp. of brazed joint	approx. 645 - 720°C approx. 720°C (acc. ISO 17672:2010) approx. 8.25 g/cm ³ max. 150 °C (without loss in strength)
Standard delivery forms* Wire: Rods: Ribbon: Preforms:	1,0 - 1,5 - 2,0 mm Ø 1,0 - 1,5 - 2,0 mm Ø, 500 mm length 0,1/ 0,2/ 0,3/ 0,4 mm thickness and 70 mm width rings, shaped parts, sections, stamped and shaped parts, lamina, discs, perforated plates
*Other delivery forms upon request	

Applications

BrazeTec S 6 is a phosphorous-containing brazing alloy with excellent flow characteristics. The brazing alloy is suitable for joining copper to copper or copper-based materials. Due to its phosphorous content, you have not to use an additional flux for brazing only copper to copper. This brazing alloy is not allowed to be used if sulfur containing medias may have contact with the joint during operating.

Further it is not allowed to use this alloy for joining steels (Fe) or materials containing iron, nickel cobalt as it will be formed brittle phases in the joint.

In refrigeration and air conditioning industries BrazeTec S 6 can be used for service temperatures down to -50°C.

It can be used for brazing with flame, with induction heating and in a furnace under protective atmospheres. Typical applications are found e.g. in the electric industry, for the refrigeration and air conditioning industry and plumbing technology.

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