TD-STM-BT-E-1319-00

Technical Data Sheet BrazeTec CSH 610 TD

Solvent based brazing paste

BrazeTec CSH 610 TD is especially developed for the copper-brass radiator brazing process (CuproBraze). It is especially designed for brazing the tube-to header joints and can be applied by so called slurry machines. The binder system is solvent based and ensures fast drying, good adhesion and a residue free burnout under protective atmosphere.

Standard

BrazeTec Standard	CPO 610

Filler

BrazeTec Standard	CuP8

Nominal composition [wt.-%]

Brazing alloy	Cu Rem.; Sn 9.3; P 6.5; Ni 5.7
Filler	Cu Rem.; P 8.3
Permitted impurities max. [wt.-%]	Al 0.010; Bi 0.030; Cd 0.010; Pb 0.025; Zn 0.050; Zn + Cd 0.050

Technical data

Melting range of brazing alloy	approx. 595 - 620 °C
Working temperature	approx. 650 °C
Metal content	> 80 wt.-%
Flux content of the brazing paste	< 3 wt.-%
Density of brazing paste	approx. 3,2 g/cm³ (20 °C)
Grain size of brazing alloy powder	< 106 µm
Viscosity	9 ± 1.5 Pa s (Cone-Plate; 150 µm; D= 1/s; 20 °C)
Drying temperature	about 100 - 120 °C at work piece
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. stir well before use

Packaging

Standard	10; 25 kg

Applications

BrazeTec CSH 610 TD is applied by special equipment (slurry machines) on the header plates. Drying takes place at temperatures between 100 °C and 120 °C at the header plate. The paste is suitable to braze wider gaps between the tubes and the header plate.

The brazing process has to be carried out in protective atmosphere using nitrogen at a brazing temperature of about 650 °C depending on brazing furnace, furnace cycle, size of parts etc.

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TVA FR 08 812 96 939
RCS Paris 812 196 939
SIREN 812 196 939

Umicore Marketing Services France
SAS - Société par actions simplifiée au capital de 400 000,00 €
9, rue Réaumur - 75003 Paris
www.umicore-brasage.fr/

Tel.: +33 (1) 85 73 78 96
Fax.: +33 (1) 43 60 52 58
commercial.umsf@umicore.com