

Tel.: +33 (1) 85 73 78 96

Fax: +33 (1) 43 60 52 58

commercial.umsf@umicore.com

## TD-STM-BT-E-1157-00

## Technical Data Sheet BrazeTec D810.6

**Standard** 

ISO 17672 CuP 182 (DIN EN 1044) (CP 201)

Nominal composition [wt.-%] Cu Rem.; P 7.8

Permitted impurities max. [wt.-%] Al 0.01; Bi 0.03; Cd 0.01; Pb 0.025; Zn 0.050; Zn + Cd 0.050;

Max. impurities [wt.-%] 0.25

**Technical data** 

Melting range of brazing alloy approx. 710 - 770 °C Recommended brazing temp 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

540 - 620 Pa s (Brookfield RVT, Sp. E, 2,5 rpm; 20 ± 1 °C) Viscosity

Flash point of solvent approx. 73 °C

Evaporation temperature of binder approx. 180 - 420 °C at 1 bar

Tensile strength with Cu: 250 MPa (acc. DIN EN 12797) 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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