

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/cm ³ (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.

Details in product brochures or other advertisements about our products, equipment, plant and processes are based on our research and our experience in the field of applied engineering and are merely recommendations. It is not possible to infer any warranted qualities or warranted use from these details, unless they were expressly agreed as a warranted quality. We reserve the right to make technical modifications in the course of our product development. The user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. This shall also apply to the protection of third party property rights as well as to applications and processes. The properties of samples and specimens are binding only if these have been expressly agreed to define the quality of the goods. Information on the quality and durability and other particulars are warranted only if these are agreed and designated as such. The specifications agreed with the user/purchaser in writing are relevant for the quality of the goods and if specifications have not been agreed in writing, the information contained in our technical data sheets, specifications or drawings.

Any additional or diverging agreements on the quality must be in writing. Any suitability of the product for the presupposed or customary use which supplements or diverges from the agreed quality is out of the question. Our General Conditions of Sale and Delivery shall apply; the current version is available at <http://www.umicore-brasage.fr>.