TD-STM-BT-E-1320-00

Technical Data Sheet BrazeTec CST 600 TD

Solvent based brazing paste
BrazeTec CST 600 TD is especially developed for the copper-brass radiator brazing process (CuproBraze). It is mainly designed for the application by spraying techniques. The binder system is solvent based and ensures fast drying, good adhesion and a residue free burnout under protective atmosphere.

Standard

BrazeTec Standard	CPO 600 (OKC 600, Patent US 5 378 294)
Nominal composition [wt.-%]	Cu Rem.; Sn 15.6; P 5.3; Ni 4.2
Permitted impurities max. [wt.-%]	Al 0.010; Bi 0.030; Cd 0.010; O 0.050; Pb 0.025; Zn 0.050; Zn + Cd 0.050

Technical data

Melting range of brazing alloy	approx. 590 - 610 °C
Working temperature	approx. 650 °C
Metal content	> 80 wt.-%
Density of brazing paste	approx. 3.4 g/cm³ (20 °C)
Grain size of brazing alloy powder	< 90 µm
Viscosity	18 ± 3,0 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 CST 600 TD can be applied on the brass tubes prior brazing manually with conventional spraying guns or automatically with spraying units. The tubes can then be dried at temperatures between 100 °C and 120 °C with standard drying processes (hot air, infrared). After drying the cores can be assembled.

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. The brazing time above 600 °C should be as short as possible and not longer than 4 minutes in case of brazing radiators to avoid critical tin-alloying of the thin fin material.

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