

## Technical Data Sheet BrazeTec S 2 Ju

### Standard

BrazeTec Standard  
(ISO 3677) (B-Cu94PAg-645/880)

### Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

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Cu remainder; Ag 2; P 4.5

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. Measurement

approx. 645 - 880°C (DSC-measurement)

Brazing temperature

approx. 760°C

Density

approx 8.1 g/cm<sup>3</sup>

Tensile strength acc. DIN EN 12797

with Cu: min. 100 MPa

Elongation

approx. 5 %

Electrical Conductivity

approx 5.4 m/ Ωmm<sup>2</sup>

Operating temp. of brazed joint

max. 150 °C (without loss in strength)

### Standard delivery forms\*

Ribbon:

0.1/ 0.2/ 0.3/ 0.4 mm thickness and 5 - 70 mm width

\*Other delivery forms upon request

### Applications

BrazeTec S 2 Ju 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 do not need to use an additional flux for brazing 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 brittle phases in the joint will be formed.

In refrigeration and air conditioning industries BrazeTec S 2 Ju 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 plumbing trade, in the electric industry and for the refrigeration and air conditioning industry.

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