

Technical Data Sheet BrazeTec 3

Standard

Alloy-No. acc. ISO 9453
(ISO 3677)

402
(Sn97Cu3)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Sn remainder; Cu 3
Pb 0.10; Sb 0.10; Bi 0.10; Au 0.05; Ag 0.10; In 0.10;
Al 0.001; As 0.03; Cd 0.002; Fe 0.02; Ni 0.01; Zn 0.001

Technical data

Melting range

approx. 227 - 310°C

Density

approx 7.3 g/cm³

Shear strength acc. DIN EN 12797

with S235: 25 MPa; with Cu 30 MPa; with Ms 20 MPa

Electrical Conductivity

approx 7.5 m/Ωmm²

Standard delivery forms*

Wire:

2.0 - 3.0 mm Ø, 250g spools

*Other delivery forms upon request

Applications

BrazeTec 3 is a soft solder free of Antimony and Lead for joining copper tubes for cold and hot water. Suitable parent metals to be joined are copper, brass and red brass.

It can be used for soldering with a flame, with resistance heating and with soldering iron. Typical applications are found e.g. in the plumbing industry.

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