

Technical Data Sheet BrazeTec Darifix 3

Standard

Alloy-No. acc. ISO 9453 (ISO 3677)	402 (Sn97Cu3)
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Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]	Sn remainder; Cu 3 Pb 0.10; Sb 0.10; Bi 0.10; Au 0.05; In 0.10; Ag 0.10; Al 0.001; As 0.03; Cd 0.002; Fe 0.02; Ni 0.01; Zn 0.001
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Technical data

Melting range	approx. 227 - 310 °C
Density	approx 7.3 g/cm ³
Shear strenght acc. DIN EN 12797	with S235: 25 MPa; with Cu 30 MPa; with Ms 20 MPa
Electrical Conductivity	approx 7.5 m/ Ωmm ²

Standard delivery forms*

Triangular rod:	edge length 12 mm, rod, length 400 mm
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Applications

BrazeTec Darifix 3 is a soft solder free of Antimony and Lead for sheet-metal work on buildings. The soft solder is suitable for any steels, copper and copper alloys, nickel and nickel alloys. It can be used for soldering with a flame and with soldering iron. BrazeTec Darifix 3 meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German association of Gas and Water). It has been awarded by the Gütegemeinschaft Kupferrohr e.V. (The coppertube Manufactures Quality Association).

Typical applications are found e.g. in sheet-metal works, gutters, roof panels and down pipes.

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