



## Technical Data Sheet BrazeTec CSH 610 TD



TD BT 1319 E.03

### Inhalt

#### 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

#### Nominal composition [wt.-%]

based on CPO 600 (OKC 600, Patent US 5 378 294)  
(Cu Rest; Sn 15,5; P 5,0; Ni 4,0)

#### 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. 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 <sup>3</sup> (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 workpiece
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.

Our information about our products and equipment as well as our systems and procedures are based on comprehensive research and application technological experience. We communicate these results, but take no liability for respective single contracts that are exceeding thereof. We reserve the right to make technical changes in the process of product development in spoken and written terms to the best of our knowledge. Only as an exception do we give guarantees for appearance and workmanship or durability that has been specifically documented in an individual contract. Furthermore, our application technology services are available at your convenience for more detailed consultation such as the involvement in solving manufacturing and application technology problems.

This does not however, release the user from their own responsibility for checking the input and recommendations we give for their own use prior to using that input or recommendation. This is especially applicable for foreign deliveries. This also applies to the trade mark rights of third parties, for applications and procedures that are not specifically given by us. In the event of damage

or loss our liability is limited to indemnification of the same admeasurements as is foreseen in our general terms of sales and delivery in reference to deficiencies in quality.