



Technical Data Sheet BrazeTec S 15



TD BT 0602 E.03

Inhalt

Standard

DIN EN 1044
ISO 3677

CP 102 (L-Ag15P acc. DIN 8513)
B-Cu80AgP-645/800

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]
0,05

Cu remainder; Ag 15; P 5
Al 0,01; Bi 0,030; Cd 0,01; Pb 0,025; Zn 0,05; Zn + Cd

Max. impurities [wt.-%]

0,25

Technical data

Melting range

approx. 645 - 800 °C (DIN EN 1044)

Working temperature

approx. 700 °C (DIN EN 1044)

Density

approx. 8,4 g/cm³

Tensile strength acc. DIN EN 12797

approx. 250 MPa with Cu

Elongation

approx. 10 %

Electrical Conductivity

approx. 7,0

m/ Ωmm²

Operating temp. of brazed joint

max. 150 °C (without loss in strength)

Standard delivery forms*

Wire:

1,0 - 1,5 - 2,0 mm Ø

Rods:

1,0 - 1,5 - 2,0 mm Ø, 500 mm length

Ribbon:

0,1/ 0,2/ 0,3/ 0,4 mm thickness and 70 mm width

Preforms:

rings, shaped parts, sections, stamped and shaped parts,
lamina, discs, perforated plates

*Other delivery forms upon request

Applications

BrazeTec S 15 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 have not to use an additional flux for brazing only 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 cobaltas it will be formed brittle phases in the joint.

In refrigeration and air conditioning industries **BrazeTec S 15** 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 electric industry and for the refrigeration and air conditioning industry.

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