



Technical Data Sheet BrazeTec S 93



TD BT 0606 E.02

Inhalt

Standard

DIN EN 1044 CP 202 (L-CuP7 acc. DIN 8513)
ISO 3677 B-Cu93P-710/820

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%] Cu remainder; P 7,0
0,05 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. 710 - 820 °C (DIN EN 1044)
Working temperature approx. 730 °C (DIN EN 1044)
Density approx. 8,05 g/cm³
Tensile strength acc. DIN EN 12797 approx. 250 MPa with Cu
Elongation approx. 5 %
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
Preforms: rings, shaped parts, sections

*Other delivery forms upon request

Applications

BrazeTec S 93 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 93** 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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Dokumenten-Informationen

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