



Technical Data Sheet BrazeTec S 94



TD BT 0605 E.02

Inhalt

Standard

DIN EN 1044 CP 203 (L-CuP6 acc. DIN 8513)
ISO 3677 B-Cu94P-710/890

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%] Cu remainder; P 6,2
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 - 890 °C (DIN EN 1044)
Working temperature approx. 760 °C (DIN EN 1044)
Density approx. 8,1 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 94 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 94** 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 plumbing trade, in the electric industry and for the refrigeration and air conditioning industry.

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.

Dokumenten-Informationen

Dokument	Helmut Ries/Wolfgang/LNWW		
Eigentümer:			
Autor(en):	Helmut Ries/Wolfgang/LNWW	Erstell-Datum:	05.07.2000 (Urversion)
	Daniel Schnee/Wolfgang/LNWW		10.10.2005 (act.Version)
Letzte ändernde Dokumentspeicherun g:	Hartmut Schmoor/Wolfgang/LNWW	Geändert-Datum:	18.10.2005
Geprüft:	Juergen Scherpf/Wolfgang/LNWW	Prüf-Datum:	17.10.2005
Freigegeben:	Hartmut Schmoor/Wolfgang/LNWW	Freigabe-Datum:	18.10.2005
Archiviert:		Archiviert-Datum:	

***** End of document *****