

## Technical Data Sheet BrazeTec BlueBraze 3510U

### Standard

Brazing Alloy:

BrazeTec Standard  
ISO 3677

B-Ag35CuZnMnSn(Si)-680/700

Flux:

DIN EN 1045  
AWS A5.31-92R

FH 10  
FB3-F

### Brazing Alloy

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### Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]  
Max. impurities [wt.-%]

Ag 35.0; Cu 32.6; Zn 20.0; Mn 10.0; Sn 2.0; Si 0.4  
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025;  
0.15

### Technical data

Melting range acc. ISO 17672  
Melting range acc. Measurement  
Brazing temperature  
Density  
Tensile strength acc. DIN EN 12797  
Elongation at rupture  
Electrical Conductivity  
Shelf life (flux)

not applicable  
approx. 680 - 700 °C (DSC-measurement)  
min. 700 °C  
approx. 8.6 g/cm<sup>3</sup>  
with S235: 320 MPa; with E295: 420 MPa  
approx. 14 %  
approx. 2,4 m/ Ωmm<sup>2</sup>  
min. 6 months, but only at storage temperatures  
between +5 to +30 °C.  
Avoid rapid changes in temperature

### Standard delivery forms\*

Rods:

1.5 - 2.0 mm Ø, 500 mm length

\*Other delivery forms upon request

### Applications

BrazeTec BlueBraze 3510U is a flux coated low melting silver based brazing alloy with excellent flow characteristics. It can be used for brazing any steels, copper and copper based alloys as well as for nickel and nickel based alloys. It can be used for flame or induction brazing procedures.

Typical applications are found e.g. in the refrigeration and air conditioning industry.

According to the experience, the fluxing activity of fluxes is also given above the date of expiry (in the original sealed packing). Please consider, that e.g. the loss or the absorption of humidity may influence the adherence of the flux coating.

**Note for user:** The flux residues are corrosive and have to be removed

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