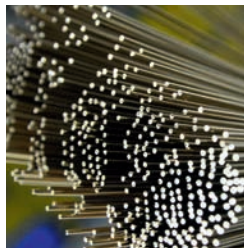


DELIVERY PROGRAM

Discover the product range and expertise of the world's leading manufacturer of brazing materials and highly pure specialist materials containing precious metals.

**BRA
ZING
ALL
OYS**

**SOL
DERS**



**BRA
ZING
FLUX**



**SOLDE
RING
FLUX**

PASTES



**SPECI
AL
MATE
RIALS**

**VACUUM
BRAZING
ALLOYS**



**EVAPORATION
MATERIALS**

AMALGAMS



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BRAZETEC: YOUR PARTNER FOR JOINING TECHNOLOGY AND SPECIALIST MATERIALS.



BRAZETEC GmbH, which is based in Alzenau, Germany, is the world's leading specialist for brazing materials and highly pure special materials containing precious metals. Our extensive product portfolio is designed to meet the needs of a wide variety of applications and industries. To fulfil specific requirements in particular industries, our products utilise the special properties of silver and gold in order to guarantee optimum results at all times.

Our Strengths: Your Advantages

/ High Reliability

Thanks to our proven expertise together with our uncompromising quality standards and customer focus, we are in demand worldwide as a partner for technically sophisticated and innovative solutions that create significant added value for our clients.

/ Innovative Product Development

We operate in accordance with best practice principles in innovation, quality and service. Our comprehensive understanding of product, process and application systems serves to secure our position as an invaluable partner in developing solutions for selected key customers. Our comprehensive understanding of product, process and application systems serves to secure our position as an invaluable partner in developing solutions for selected key customers.

/ Wide-ranging Product Portfolio

Our product range includes brazing alloys and solders in regular and vacuum qualities. We also provide pastes, fluxes, amalgams, vacuum evaporation materials and premium specialist materials.

/ Consulting

In addition to our extensive product range, which covers all kinds of functional materials, we also offer competent application advice as well as seminars and training programmes where you can learn from our expertise.



Sustainable Business Practices for a Better Future

We believe that sustainability is a collective responsibility. This means that it is also our concern: We have therefore implemented a series of sustainable measures to orientate our production processes towards the latest environmental standards.

BRAZETEC SILVER BRAZING ALLOYS

FOR SPECIAL APPLICATIONS



/ BRAZETEC Silver Brazing Alloys for Special Applications

BrazeTec 7200 and BrazeTec 6009 brazing alloys can be brazed in air with flux as well as in a protective atmosphere furnace without flux. BrazeTec 6009 is used with flux BrazeTec special h for the brazing of stainless steel. The brazing processes in a vacuum should not exceed

900 °C for both brazing alloys to avoid the evaporation of silver. The furnace brazing temperature is governed in accordance with the base material.

Name	Composition by Weight-%					Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Density	ISO 17672	Notes on Application	Available Forms			
SilverBrazing Alloys	Ag	Cu	Sn	Zn	Mn	in °C	in °C	in °C	in g/cm³						
BrazeTec 7200	72	28	–	–	–	780	780	780	10.0	Ag 272	metallized ceramic	•	•	•	•
BrazeTec 7291	72	–	–	28	–	710 – 730	–	730	8.4	–	any steel; suitable for aggressive media	•	•	•	•
BrazeTec 6009	60	30	10	–	–	600 – 720	600 – 730	720	9.8	Ag 160	stainless steel	•	•	•	•
BrazeTec 8500	85	–	–	–	15	–	960 – 970	960	9.4	Ag 485	any steel; suitable for aggressive media	•	•	•	•

Brass Brazing Alloys	Cu	Zn	Ni	Sn	Si	Mn	in °C	in °C	in °C	in g/cm³					
BrazeTec 60/40	60	39.55	–	0.2	0.3	0.15	870 – 900	870 – 900	900	8.4	Cu 670	galvanized steel pipes	•	•	•
BrazeTec 48/10	48	41.8	10	–	0.2	–	890 – 920	890 – 920	920	8.4	Cu 773	steel pipe frames	•	•	–

BRAZETEC ACTIVE BRAZING ALLOYS AND ACTIVE BRAZING PASTES

BRAZING
ALL
ALOYS

PASTES



/ BRAZETEC Active Brazing Alloys

With BRAZETEC active brazing alloys, a minimum soldering temperature of 850 °C is required to achieve a bond with the ceramic. The wettability can be improved by using higher brazing temperatures. Pure argon (4.8) or a vacuum ($<10^{-3}$ mbar) are recommended as

brazing atmospheres. In the case of vacuum brazing with BrazeTec CB 4, the brazing temperature should not be significantly above 900 °C and not significantly above 1000 °C when using BrazeTec CB 2 and BrazeTec CB 6, in order to avoid evaporation of the silver.

Name	Composition by Weight-%				Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Density	Notes on Application	Available Forms			
	Ag	Cu	In	Ti	in °C	in °C	in °C	in g/cm ³					
BrazeTec CB 2	96	–	–	4	970	–	1,000	10.3	ceramic, ceramic/metal-connections, graphite, diamond, sapphire, ruby	•	•	•	•
BrazeTec CB 4	70.5	26.5	–	3	780 – 820	–	850	9.9	ceramic, ceramic/metal-connections, graphite, diamond, sapphire, ruby	•	•	•	•
BrazeTec CB 6	98.4	–	1	0.6	950 – 960	–	1,000	10.3	silicon nitride	•	•	•	•

/ BRAZETEC Active Brazing Pastes

BRAZETEC active brazing pastes have a high metal content that is optimised for the use of the product. Alloys with different amounts of titanium and differing compositions are available by request.

The rheological properties of the active brazing paste can also be precisely adjusted for the respective paste application. Adjustment of the paste application with a reduced wet film thickness is also possible.

Name	Composition by Weight-%				Melting Range acc. to DSC	Brazing Temp. min.	Notes on Application	Available Forms
	Ag	Cu	In	Ti	in °C	in °C		
BrazeTec CB 10	64.8	25.2	–	10	780 – 805	850	ceramic, ceramic/metal-connections, graphite, sapphire, ruby	• •
BrazeTec CB 11	90	–	–	10	970	1,000	ceramic, ceramic/metal connections, PCD, CBN applications	• •
BrazeTec CB 12	55.1	39.9	–	5	780 – 855	>900	ceramic, ceramic/metal connections	• •
BrazeTec CB 14	68.4	26.6	–	5	720 – 785	850	ceramic, ceramic/metal connections, PKD	• •
BrazeTec CB 16	44	29	24	3	460 – 620	650 – 850	ceramic, ceramic/metal connections, PCD, CBN applications	• •
BrazeTec CB 17	59.1	27.2	12.5	1.2	605 – 720	780 – 850	ceramic, ceramic/metal connections, PCD, CBN applications	• •

BRAZETEC BRAZING ALLOYS AND SANDWICH ALLOYS FOR THE BRAZING OF CARBIDES



/ BRAZETEC Brazing Alloys for the Brazing of Carbides

The mentioned BRAZETEC brazing alloys are suitable for the brazing of carbides and hard to wet materials such as wolfram, molybdenum,

tantalum and chrome. The strength achieved depends upon the base material.

Name	Composition by Weight-%						Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Shear Strength ¹⁾ min.	Density	ISO 17672	Notes on Application	Available Forms			
	Ag	Cu	Zn	Mn	Ni	Misc.	in °C	in °C	in °C	in MPa	in g/cm ³						
BrazeTec 6488	64	26	–	2	2	6 In	730 – 780	–	770	150	9.6	–	TiN-coatable	•	•	•	•
BrazeTec 5081	50	20	28	–	2	–	670 – 730	660 – 715	700	230	9.2	Ag 450	–	•	•	•	•
BrazeTec 4900	49	16	23	7.5	4.5	–	680 – 705	680 – 705	690	250	8.9	Ag 449	–	•	•	•	•
BrazeTec 4900 A	49	27.5	20.5	2.5	0.5	–	670 – 720	–	710	240	8.9	–	–	•	•	•	•
BrazeTec 2700	27	38	20	9.5	5.5	–	690 – 850	680 – 850	800	250	8.7	Ag 427	–	•	•	•	•
BrazeTec 21/75	–	75	–	22	3	–	905 – 930	–	945	220	8.1	–	zinc-free alloys suitable for furnace brazing	–	–	•	•
BrazeTec 21/80	–	86	–	12	2	–	970 – 1,005	–	990	200	8.8	–		•	•	•	•
BrazeTec 21/68	–	87	–	10	–	3 Co	980 – 1,020	–	1,020	200	8.8	–		•	•	•	•

¹⁾ Measured according to BRAZETEC standard, compound 1.2210 & K10

/ BRAZETEC Sandwich Alloys for the Brazing of Carbides

BRAZETEC has developed special sandwich alloy brazing systems for brazing carbides that can compensate internal stresses caused by the different thermal expansion coefficients during cooling. We recom-

mend the sandwich brazing alloy BrazeTec 49/Cu plus for applications that require an especially high degree of shear strength. The strength to be achieved depends upon the strength of the base material.

Name	Composition ¹⁾ by Weight-%						Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Shear Strength ²⁾ min.	Density	Notes on Application	Available Forms	
	Ag	Cu	Zn	Mn	Ni	In	in °C	in °C	in °C	in MPa				
BrazeTec 49/Cu	49	27.5	20.5	2.5	0.5	–	670 – 720	–	710	150	9.0	intermediate copper layer	•	•
BrazeTec 49/Cu ^{plus}	49	27.5	20.5	2.5	0.5	–	670 – 720	–	710	180	9.0	modified intermediate layer	•	•
BrazeTec 49/NiN	49	27.5	20.5	2.5	0.5	–	670 – 720	–	710	150	9.0	nickel net sandwich brazing alloy	•	•
BrazeTec 49/CuNiFe	49	27.5	20.5	2.5	0.5	–	670 – 720	–	710	150	9.0	intermediate CuNiFe layer	•	•
BrazeTec 64/Cu	64	26	–	2	2	6	730 – 780	–	770	150	9.6	suitable for TiN coating, intermediate copper layer	•	•
BrazeTec Cu/NiN	–	100	–	–	–	–	1,085	1,085	1,100	200	8.9	nickel net sandwich brazing alloy	•	•

¹⁾ The data on the composition of sandwich brazing alloys refer only to the brazing layer. ²⁾ Measured according to BRAZETEC standard, compound 1.2210 & K10

/ BRAZETEC BlueBraze for the Brazing of Carbides

Less silver: up to 21 percent less in weight!

By substantially reducing the silver content in our innovative BrazeTec BlueBraze brazing alloys, you achieve permanent cost reduction up to 21%*. You become less dependent on silver price fluctuation in the market of precious metals and thus get more planning stability when calculating the cost of your materials.

Comparable processing properties:

Construction, processes and processing remain unchanged. During the development of BrazeTec BlueBraze, apart from reducing silver content, the top priority was retaining the important properties of materials of standard brazing alloys. The functionality of BrazeTec BlueBraze has been confirmed in extensive tests and experiments. For you as a customer, this means that neither constructions nor processes must be changed. Processing continues as usual.

Name	Composition by Weight-%						Melting Range acc. to DSC approx. in °C	Brazing temp. approx. in °C	Shear strength ¹⁾ min. in MPa	Density in g/cm ³	ISO 17672	Available Forms				
	Ag	Cu	Zn	Mn	Ni	In										
BrazeTec BlueBraze 2810	28	39	20	10	1	2	680 – 760	710	>250	8.7	–	•	•	•	•	•
BrazeTec BlueBraze 28/Cu	28	39	20	10	1	2	680 – 760	710	>150	8.7	–	–	–	•	•	•
BrazeTec BlueBraze 28/Cu ^{plus}	28	39	20	10	1	2	680 – 760	710	>180	8.7	–	–	–	•	•	•

¹⁾ depends on the product, the amount and the silver price ¹⁾ Measured according to BrazeTec standard, compound 1.2210 & K10



/ BRAZETEC Silver Brazing Alloys, Cadmium-free

The silver brazing alloys shown on this page are generally capable of being used for operating temperatures from –200 °C to +200 °C. They can be used with any type of steel, copper and copper alloy, also nickel and nickel alloy. The tin-free brazing alloys are particularly suitable for dynamic operating loads. Other brazing alloys are available on request or can be customised.

Name	Composition by Weight-%				Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Density	ISO 17672	Shear Strength acc. to DIN EN 12797 min.	Available Forms			
	Ag	Cu	Zn	Misc.	in °C	in °C	in °C	in g/cm³		in MPa on S 235				
BrazeTec 5662	56	19	17	5 Sn/3 Ga	605 - 630	-	630	9.3	-	150	•	•	-	-
BrazeTec 5600	56	22	17	5 Sn	630 - 655	620 - 655	655	9.4	Ag 156	150	•	•	•	•
BrazeTec 5507	55	21	22	2 Sn	650 - 670	630 - 660	670	9.3	Ag 155	150	•	•	•	•
BrazeTec 4576	45	27	25.5	2.5 Sn	645 - 695	640 - 680	695	9.1	Ag 145	150	•	•	•	•
BrazeTec 4076	40	30	28	2 Sn	665 - 725	650 - 710	725	9.0	Ag 140	150	•	•	•	•
BrazeTec 3476	34	36	27.5	2.5 Sn	665 - 745	630 - 730	745	8.9	Ag 134	150	•	•	•	•
BrazeTec 3076	30	36	32	2 Sn	675 - 760	665 - 755	760	8.8	Ag 130	150	•	•	-	•
BrazeTec 2576	25	40	33	2 Sn	680 - 775	680 - 760	775	8.8	Ag 125	150	•	•	-	•
BrazeTec BlueBraz 3510	35	32.6	20	10 Mn/2.0 Sn/0.4 Si	680 - 700	-	700	8.6	-	150	•	•	-	•
BrazeTec BlueBraz 3010	30	37.8	20	10 Mn/2.0 Sn/0.2 Si	690 - 730	-	730	8.4	-	150	•	•	-	•
BrazeTec BlueBraz 2410	24	43.7	20	10 Mn/2.0 Sn/0.3 Si	690 - 750	-	750	8.4	-	150	•	•	-	•
BrazeTec BlueBraz 2010	20	42.8	25	10 Mn/2.0 In/0.2 Si	710 - 765	-	765	8.3	-	150	•	•	-	•
BrazeTec 4404	44	30	26	-	675 - 735	675 - 735	735	9.1	Ag 244	150	•	•	•	•
BrazeTec 3075	30	38	32	-	700 - 775	680 - 765	775	8.8	Ag 230	150	•	•	•	•
BrazeTec 2500	25	40	35	-	715 - 790	700 - 790	790	8.7	Ag 225	150	•	•	-	•
BrazeTec 2009	20	44	35.8	0.15 Si	730 - 810	-	810	8.6	Ag 220	150	•	•	-	•

Most alloys can be supplied with 0.15% Si

/ BRAZETEC CoMet Brazing Rods, with Boric Acid-free Coating & Cadmium-free

BRAZETEC offers the following cadmium-free brazing alloys from its comprehensive range of products under the name of BrazeTec CoMet (**Coated Metal**) as flux coated rods as well. These are naturally free from harmful solvents, plastics and boric acid.

The flux is equivalent to type FH 10 in accordance with DIN ISO 18496. The respective instructions for the use of cadmium-free brazing alloys are effective for its application. The silver content by weight of the coated brazing rod is lower than the silver content of a bare brazing rod because of the flux coating. The content of the bare brazing rod of course meets the composition found in cadmium free brazing alloys. BrazeTec CoMet coated rods are available with different thickness ratio of flux coating and core wire in the range of 1.3-2.4 as standard according to customer requirements. Other brazing alloys with flux coating are also available on request.



Name	Melting Range acc. to DSC	Brazing Temp. min.	Available Forms
	in °C	in °C	
BrazeTec CoMet 5600 U	630 – 655	655	•
BrazeTec CoMet 5507 U	650 – 670	670	•
BrazeTec CoMet 4076 U	665 – 725	725	•
BrazeTec CoMet 3476 U	655 – 745	745	•
BrazeTec CoMet 3076 U	675 – 760	760	•
BrazeTec CoMet 2576 U	680 – 775	775	•
BrazeTec BlueBraze CoMet 2410 U	690 – 750	750	•
BrazeTec CoMet 4404 U	675 – 735	735	•
BrazeTec CoMet 3075 U	700 – 775	775	•
BrazeTec CoMet 2577 U	710 – 795	795	•
BrazeTec CoMet 2009 U	730 – 810	810	•
BrazeTec CoMet 4900 U	680 – 705	690	•

Most alloys can be supplied with 0.15% Si

BRAZETEC BRAZING ALLOYS FOR COPPER AND COPPER-BASED ALLOYS



/ BRAZETEC Copper-Phosphorous Brazing Alloys for Copper and Copper-based Materials

The BrazeTec copper-phosphorous brazing alloys can be used at operating temperatures from $-70\text{ }^{\circ}\text{C}$ to $+150\text{ }^{\circ}\text{C}$, depending on the type. These phosphorous containing brazing alloys were especially developed for the joining of copper with copper or of copper alloys (brass, bronze, red brass). The use of an additional flux is not necessary when brazing copper to copper due to its phosphorous-content. These brazing alloys should not be used in the brazing of materials that contain sulphur. These brazing alloys are not suitable for steels and nickel alloys due to brittle-phase-generation. The BrazeTec S 2 and BrazeTec S 94 brazing alloys are in line for use according to the DVGW recommendations, and can be used for copper pipe installations.

Name	Composition by Weight-%				Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Density	ISO 17672	Tensile Strength acc. to DIN EN 12797 min.	Available Forms			
	Ag	Cu	P	Sn	in $^{\circ}\text{C}$	in $^{\circ}\text{C}$	in $^{\circ}\text{C}$	in g/cm^3		in MPa on Cu				
BrazeTec S 18	18	75	7	–	645	645	650	8.3	CuP 286	100	•	•	–	–
BrazeTec S 15	15	80	5	–	645 – 800	645 – 800	700	8.3	CuP 284	100	•	•	•	•
BrazeTec S 5	5	89	6	–	645 – 815	645 – 815	710	8.2	CuP 281a	100	•	•	•	•
BrazeTec S 2	2	91.7	6.3	–	645 – 845	645 – 825	740	8.1	CuP 279	100	•	•	•	•
BrazeTec S 94	–	93.8	6.2	–	710 – 860	710 – 890	760	8.1	CuP 179	100	•	•	–	•
BrazeTec S 93	–	93	7	–	710 – 820	710 – 820	730	8.1	CuP 180	100	•	•	–	•
BrazeTec S 92	–	92.2	7.8	–	710 – 780	710 – 770	720	8.0	CuP 182	100	•	•	–	–
BrazeTec S 86	–	86.2	6.8	7	640 – 720	650 – 700	700	8.0	CuP 386	100	•	–	–	–

BRAZETEC BRAZING FLUXES



/ BRAZETEC Brazing Fluxes

The choice of flux is made in accordance with the working temperature of the brazing alloy and the base materials. The working temperature or melting range of the brazing alloy should be within the effective tem-

perature range of the flux. The effective temperature ranges specified are derived from our extensive research. Additional fluxes for special applications are available upon request.

Name	ISO 18496	Effective Temperature Range ¹⁾	Available Forms				Notes on Application
			in °C	Powder (A)*	Paste (B)*	Dispensable Paste (B)*	
BrazeTec h	FH 10	550 – 970	•	•	–	–	universal flux for heavy metals
BrazeTec h 28	FH 10	580 – 940	–	•	–	–	flux for automated brazing
BrazeTec h 80	FH 10	550 – 850	–	•	–	–	flux for brazing of larger areas
BrazeTec h 86	FH 10	550 – 850	–	•	–	–	flux for brazing of larger areas
BrazeTec h 280	FH 10	520 – 850	–	–	•	–	flux for automated brazing
BrazeTec r 1	FH 10	520 – 630	–	–	–	•	flux for non-ferrous metals for special tools
BrazeTec d	FH 10	550 – 850	•	–	–	–	flux for any steel type, non-ferrous metals for special
BrazeTec d 21	FH 10	520 – 760	•	–	–	–	powder-type flux for steel („hot rodding“)
BrazeTec f	FH 10	610 – 1.025	–	•	–	–	prevention of red staining in copper alloys
BrazeTec l	FH 11	490 – 730	–	•	–	–	flux for heavy metals with up to 10% aluminium
BrazeTec lpb	FH 11	490 – 730	–	•	–	–	flux for aluminium-containing heavy metals up to 10 % aluminium; special materials that are difficult to wet, e.g. materials containing lead
BrazeTec spezial h	FH 12	520 – 1.030	•	•	–	–	flux for stainless and scale resistant steels, carbides, special materials
BrazeTec h 90	FH 12	520 – 850	•	–	–	–	flux for special carbides
BrazeTec h 285	FH 12	520 – 910	–	–	•	–	flux for automated brazing, also suitable for carbide brazing
BrazeTec h 900	FH 12	520 – 820	–	–	•	–	flux for machine brazing for special carbides
BrazeTec s	FH 20	650 – 1.050	•	•	–	–	flux, also for high-alloy-steel, Ni-alloys, carbides. non-corrosive flux residues
BrazeTec spezial s	FH 22	650 – 1.050	–	•	–	–	flux, also for high-alloy-steel, Ni-alloys, carbides, non-corrosive flux residues
BrazeTec rs a	FH 21	800 – 1.100	–	•	–	–	flux for copper and copper alloys, steels, nickel alloys; non-corrosive flux residues
BrazeTec ms	FH 21	700 – 1.100	•	–	–	–	flux for copper and copper alloys, steels, nickel alloys; non-corrosive flux residues
BrazeTec t	–	600 – 980	–	–	–	•	low-viscosity flux; for special applications such as resistance brazing

¹⁾ On S235 in furnace at atmosphere: Suitable brazing filler metal must wet and flux shouldn't be burnt completely.

* Since the amendment to international standard ISO 18496 in 2021, the delivery form must be specified on the label.

/ BRAZETEC Antiflux

Antiflux agents BrazeTec Antiflux ASV and BrazeTec Antiflux C prevent the wetting of the brazing alloy on surfaces

that should not be wet and thereby permits selective and precise brazing.

Name	Delivery Form	Brazing Procedure	Brazing Atmosphere
BrazeTec Antiflux ASV	paste	soft soldering, brazing and high temperature brazing	air, protective gas, vacuum
BrazeTec Antiflux C	paste	soft soldering, brazing and high temperature brazing	air, protective gas, vacuum

BRAZETEC SOFT SOLDERS AND FLUXES HEAT PROTECTION MAT AND CLEANING PAD



/ BRAZETEC Soft Soldering Pastes for Plumbing Technology

The soft soldering pastes BrazeTec Degufit® 3000 and BrazeTec Degufit® 4000 are a mixture of soft solder powder, flux and a binder. They are applied as flux, and contribute to a high filling level of the soldering gap

and thus to greater strength. They also prevent overheating of the pipes and fittings, as reaching the brazing temperature is clearly visible. The application of an additional soft solder may be necessary.

Name	Composition by Weight-%			Melting Range	Alloy according to DIN EN ISO 9453	Flux according to DIN EN ISO 9454	To be used together with	Available Form
	Sn	Ag	Cu	in °C				
BrazeTec Degufit® 3000	97	–	3	227 – 310	402	3.1.1.4.	BrazeTec 3	•
BrazeTec Degufit® 4000	97	3	–	221 – 224	702	3.1.1.4.	BrazeTec 4	•

/ BRAZETEC Soft Solders for Plumbing Technology

The soft solder materials BrazeTec 3 and BrazeTec 4 are in line for copper tube installation according to the DVGW (German Technical and

Scientific Association for Gas and Water). They are supplied in a handy 250 g coil. BrazeTec Darifix 3 is primarily used in building plumbing.

Name	Composition by Weight-%			Melting Range	DIN EN ISO 9453	Suitable for Soft Soldering in Plumbing Technology		Alternative Processing with Flux DIN EN ISO 9454 3.1.1.4./Soft Solder Paste	Available Forms	
	Ag	Cu	Ti	in °C	in °C	Tube Material	Fitting Material			
BrazeTec 3	97	–	3	227 – 310	402	copper	copper, brass	BrazeTec Soldaflux® 7000	•	–
							red, brass	BrazeTec Degufit® 3000		
BrazeTec 4	97	3	–	221 – 224	702	copper	copper, brass	BrazeTec Soldaflux® 7000	•	–
							red, brass	BrazeTec Degufit® 4000		
BrazeTec Darifix 3 ¹⁾	97	–	3	227 – 310	402	soft soldering of copper in construction plumbing (gutters, downpipes, etc.)		BrazeTec Soldaflux® 7000	–	•

¹⁾ Delivery form: Rods 12 x 12 x 400 mm

/ BRAZETEC Soldamoll® Special Soft Solders

BrazeTec Soldamoll® special soft solders can be used in many application areas. They can be used for the brazing of brass, steel and copper components amongst other things.

Name	Composition by Weight-%				Melting Range	Density	Shear Strength in MPa			Electrical Conductivity	DIN EN ISO 9453	Notes on Application	Available Forms			
	Sn	Ag	Cu	Sb	in °C	in g / cm³	Cu	Ms	S 235	in m/Ωmm²						
BrazeTec Soldamoll® 220	96.5	3.5	–	–	221	7.3	30	20	25	7.5	703	exceptional wetting, water installations	•	•	•	•
BrazeTec Soldamoll® 230	97	–	3	–	227 – 310	7.3	30	20	25	7.5	402	–	•	–	•	–
BrazeTec Soldamoll® 235	95	–	–	5	235 – 240	7.2	30	20	30	6.2	201	–	•	•	–	–

/ BRAZETEC Soldaflux® Soft Solder Fluxes

BrazeTec Soldaflux® soft solder fluxes are corrosive. For this reason, all flux residues must be removed from the component by boiling in water after brazing.

Name	Effective Temperature Range	Type of Residues	Residues soluble in	DIN EN 9454	Notes on Application	Aviable Form
	in °C					
BrazeTec Soldaflux® 7000	150 – 400	limited corrosive	water	3.1.1.A	carbon steel, non-ferrous-metals, copper tube installation	•
BrazeTec Soldaflux® K	150 – 450	highly corrosive	water	3.1.1.A	carbon steel, non-ferrous-metals	•
BrazeTec Soldaflux® Z	150 – 450	highly corrosive	water	3.1.1.A	stainless and scale resistant steel	•
BrazeTec Soldaflux® Z 30	150 – 450	highly corrosive	water	3.1.1.A	steel, non-ferrous-metals	•

/ BRAZETEC Heat Protection Mat

This asbestos free heat protection mat has the beneficial property of high-quality non-melting fibrous web and the mechanical properties of textile glass products. The dense two-ply woven edition with stitches that are sewn with high-quality fireproof metal sewing thread, reduces the air permeability without adversely affecting the flexibility. An additional interlayer made of metal foil improves the insulation attributes as well as the heating insulation, and fosters form stability with loose casings. The heat protection mat protects the environ-

ment of the brazing joint from the burner flame. Direct heating of the brazing joint by the burner should be avoided. The BrazeTec heat protection mat is heat resistant for temporary exposure to temperatures from 300°C to 1000°C. The fusibility is delayed by an extended period of time due to a special type of treatment. The mat is only conditionally resistant against acids and alkaline, however, it can be exposed to oils and greases without reservations.

/ BRAZETEC Cleaning Pad

Non-woven cleaning cloth for cleaning the ends of copper pipes.

Advantages of using the cleaning pad:

- No metallic abrasion
- Fast pipe cleaning free from scoring lines

The fabric has a long life as it can be cleaned repeatedly by shaking out or washing. Oil and grease residues can be removed, as the cleaning pad is solvent resistant.

BRAZETEC BRAZING PASTE

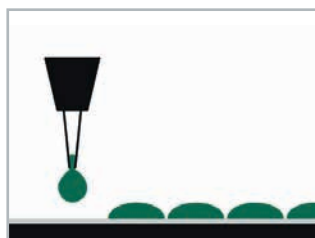


/ BRAZETEC Brazing Paste Systems

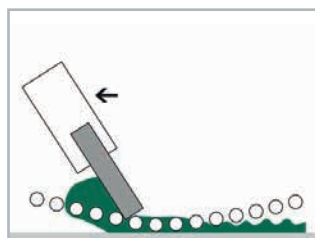
For innovative connection possibilities, BRAZETEC also offers brazing materials as pastes, in addition to the solid forms. A brazing paste is a homogeneous, ready to use, mixture of metallic brazing powder, flux and solvents. Polymers and other additives prevent the settlement of the brazing powder and determine the application and flow characteristics of the brazing paste. The following processes are available for the application according to the task in hand. BRAZETEC offers tailor-made brazing paste systems for these application processes. For this

purpose, a wide range of binder systems and brazing paste formulations have been developed and can be further adapted for specific customer processes. Brazing pastes are particularly suitable for automated brazing processes, because they can be easily integrated into a production process. They enable the optimum use of materials for both small and large series production. The specified brazing pastes are available in cans or cartridges as standard by request.

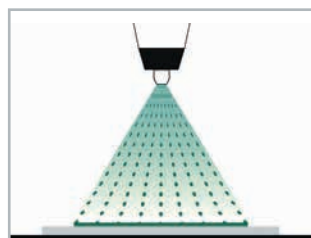
Application Processes



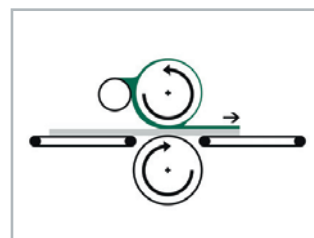
D = Dispensing



P = Screen-/ Stencil Printing



S = Spraying



R = Rollercoating

/ BRAZETEC Silver-based Brazing Paste

The silver-based flux-containing BRAZETEC brazing pastes can be used to braze any steel, copper, nickel, and copper alloy. They can be applied with a dispenser or by screen printing.

The brazing pastes shown below are available on a standard basis, and depending on the application, contain flux or are flux free. Additional alloys and compositions are available upon request.

Name	Composition by Weight-%						Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp.	ISO 17672	Notes on Application
	Ag	Cu	Zn	Mn	Ni	Misc.	in °C	in °C	in °C		
BrazeTec D 7200	72	28	–	–	–	–	780	780	780	Ag 272	any steel, copper-Ni and Ni-alloys
BrazeTec D 6488	64	26	–	2	2	6 In	730 – 780	–	770	–	TiN- coatable
BrazeTec D 5600	56	22	17	–	–	5 Sn	630 – 655	620 – 655	655	Ag 156	any steel, copper-Ni and Ni-alloys
BrazeTec D 5081	50	20	28	–	2	–	670 – 730	660 – 715	700	Ag 450	cemented carbides
BrazeTec D 4900	49	16	23	7.5	4.5	–	680 – 705	680 – 705	690	Ag 449	cemented carbides
BrazeTec D 4576	45	27	25.5	–	–	2.5 Sn	645 – 695	640 – 680	695	Ag 145	any steel, copper-Ni and Ni-alloys
BrazeTec D 3375	33	33.5	33.5	–	–	–	670 – 760	–	760	–	any steel, copper-Ni and Ni-alloys

/ BRAZETEC Copper-based Brazing Paste

The CuproBraz®-Process was developed especially for the flux free brazing of copperbrass radiators in protective gas furnaces. The brazing material used in this process is a phosphorous containing copper alloy. The radiators are produced in a manner that displays high resis-

tance with high working temperatures as well. The different solvent-based pastes can be applied by spraying onto the tubes (BrazeTec CST 600 TD) or through special roller-coating onto the fins. Of course, these pastes can also be used for Copper-Copper-Brazing.

Name	Composition by Weight-%					Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp.	ISO 17672	Atmosphere ¹⁾				Notes on Application
	Cu	Sn	Ni	P	Ag					A	B	C	D	
BrazeTec D 801	100	–	–	–	–	1,083	1,083	1,120	Cu 110	•	•	•	•	Any steel, Ni and Ni alloys
BrazeTec D 807	80	–	–	5	15	645 – 800	645 – 800	720	CuP 284	•	–	•	–	Cu and Cu alloys suitable for resistance brazing
BrazeTec D 810	92	–	–	8	–	710 – 770	710 – 770	750	CuP 182	•	–	•	–	Cu and Cu alloys
BrazeTec D 813	75	–	–	7	18	645	645	695	CuP 286	•	–	•	–	Cu and Cu alloys suitable for resistance brazing

Brazing paste systems for the CuproBraz® process

BrazeTec CST 600 TD	76	15.6	4.2	5.3	–	590 – 610	–	650	–	•	–	•	–	Paste for preliminary brazing of tubes by means of spray application for the CuproBraz® process
BrazeTec CSF 600 TD	76	15.6	4.2	5.3	–	590 – 610	–	650	–	•	–	•	–	Paste for preliminary brazing of fin tips by means of roller application for the CuproBraz® process

¹⁾ A = dry hydrogen B = vacuum C = H₂N₂-gas atmospheres (dew point: –30 °C) D = exogas

/ BRAZETEC Nickel-based Brazing Paste

The modern BRAZETEC application systems can be used for almost all known powder-type nickel-based brazing alloys. The products shown above are available as standard products. Modifications to the standard alloys are possible by request in close consultation with the

customer. Among others, the application of the BRAZETEC nickel-based brazing pastes is commonly practiced in heat exchangers and the automotive industry.

Name	Composition by Weight-%						Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp.	ISO 17672	Atmosphere ¹⁾			Application Processes ²⁾				
	Ni	Cr	Fe	Si	B	P					A	B	C	P	R	S	D	S
BrazeTec 897	76	14	–	–	–	10	890	890	980	Ni 710	•	•	•	•	–	•	•	•
BrazeTec 1002	82.4	7	3	4.5	3.1	–	970 – 1,000	970 – 1,000	1,050	Ni 620	•	•	–	•	•	•	•	•
BrazeTec 1090	60	30	–	4	–	6	980 – 1,040	–	1,090	–	•	•	•	–	•	–	•	•
BrazeTec 1130	72	18	–	8	–	2	1,050 – 1,090	–	1,080	–	•	•	•	–	–	–	•	–
BrazeTec 1135	70.9	19	–	10.1	–	–	1,080 – 1,135	1,080 – 1,135	1,190	Ni 650	•	•	•	•	•	•	•	•

¹⁾ A = dry hydrogen B = vacuum C = H₂N₂-gas atmospheres (dew point: –30° C) ²⁾ D = Dispensing P = Screen-/Stencil Printing S = Spraying R = Rollercoating

EVAPORATION MATERIALS

/ BRAZETEC Materials 99.999%

Precious metal-based thin films are predominantly used in the semiconductor industry as well as in many other branches of industry. BRAZETEC offers highly pure evaporation materials in different

compositions, shapes and sizes, specifically developed to fulfil the demanding requirements of numerous PVD applications.

Compositions of the common Precious Metal Alloys

Ag	*
Al	*
Au	*
AuAs ₄	*
AuGe1	*
AuGe2	*
AuGe3	*
AuGe12	*
Sn	*
Pd	99.98 %

* total metallic impurities in matrix < 10 ppm

Packaging

All evaporation materials are vacuum sealed in cleanroom bags under cleanroom conditions, guaranteeing consistent performance, even when stored for a longer period of time.

Dimensions

The standard dimensions are:

	Wire	diameter from 0.75 mm to 3.0 mm
	Slug	diameter from 2.0 mm to 10 mm Wire section length from 4.0 mm up to 50 mm
	Discs	diameter from 5 mm to 50 mm Thickness from 1.5 mm to 14 mm

Special forms possible on request

For alloys, which are not listed, please contact us.



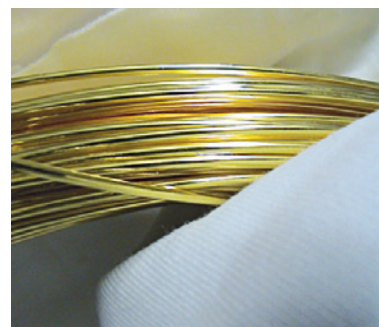
Au 5N ø 20 x 1.5 mm discs



Au 5N 6 x 12 mm slugs



AuAs 0.4% ø 5 x 11.1 mm slugs



Au 5N ø 2.0 mm wire



Ag 5N ø 13.5 x 25 mm slugs



Pd ø 2 x 4 mm slugs



/ BRAZETEC High Purity Vacuum Brazing Alloys

BRAZETEC high purity vacuum brazing materials are applied in a variety of applications like vacuum interrupters, surge arresters, and X-ray tubes. For these applications the alloys have to fulfil the high requirements of low gas content and low content of elements which have a high vapour pressure.

Besides the wetting behaviour of the brazing alloy on the base materials used, the joining quality for brazing as well as on an appropriate brazing process. Typically, the recommended brazing temperature is above the liquidus temperature of the brazing material. Please do not hesitate to contact us for further information.

Soft Solder Alloy Properties

	Melting Range acc. to DSC	Density	Coefficient of thermal Expansion	Thermal Conductivity*	Electrical Conductivity*	Young's Modulus*
	[°C]	[g/cm³]	[x 10 ⁻⁶ 1/K]	[W/(m*K)]	[m/(Ω*mm²)]	[GPa]
AgCu28	780	10.0	17.8	352	46.1	100
AgCu28Ni0.7	780 - 800	9.8	19.2			
AgCu28Ge2Co0.3	770 - 790	9.9	19.6			
AgCu26.6Pd5	800 - 820	9.8	22.0	215	26.0	120
AgCu31.5Pd10	820 - 840	9.8	17.5	150	19.0	140
AgCu20Pd15	845 - 870	10.2	22.0	100	15.0	140
AgCu21Pd25	900 - 950	9.8	17.5	80	8.0	140
CuAg40Ga10	725 - 830	9.3	19.6			
AgCu27In13	610 - 710	9.8	19.8		10.0	85
AgCu42Ni2	780 - 810	9.5	18.7			
AlSi11.7	593	2.7	23.6			

*Literature values

*Further alloy compositions on request



/ BRAZETEC Dosing Amalgams and Alloys

BRAZETEC dosing amalgams and alloys are mainly used in the manufacturing process of UV lamps. Available delivery forms include wires and slugs.

Applications

- UV lamps
- Induction lamps

Standard Alloy Composition

The material selection is mainly determined by the optimum mercury vapour pressure and the maximum mercury content. The delivery form should correspond to the preferred singulation or dosing process used to manufacture the desired lamp.

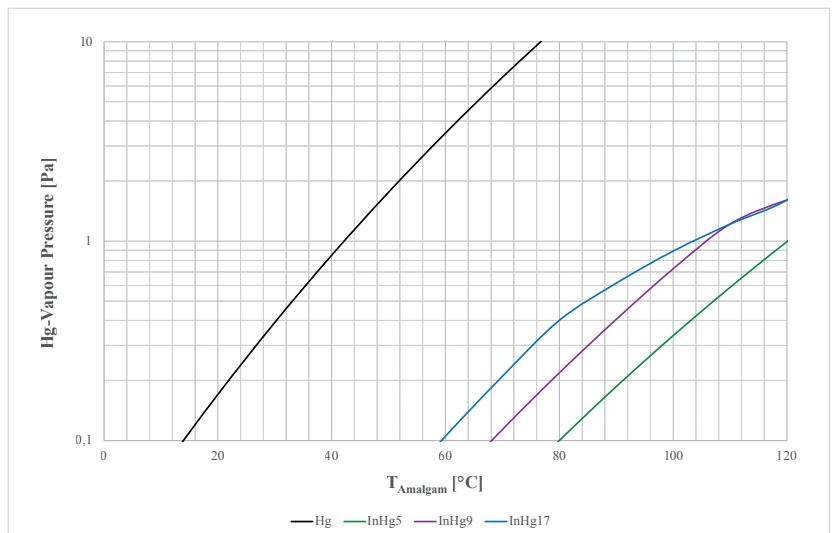
The BRAZETEC product portfolio includes, for example, the following amalgams: Hg, In, InHg (Hg 3 - 17 % by weight), InAg18Au2, InHgAg and BiIn30

Sustainability

BRAZETEC attaches great importance to the selection of raw materials with a high purity. This ensures the availability of high purity amalgams resulting in outstanding performance. Furthermore BRAZETEC emphasizes the responsibility towards our environment by using mercury only from recycled sources.

Hg Vapour Pressure Curves

The following diagram shows the vapour pressure curves of selected examples of some available dosing InHg-amalgams suitable for the use in different types of lamps.





/ BRAZETEC High Purity Soft Solders

The BRAZETEC high purity soft solder alloys offer the ideal solution for the assembly of advanced high-performance components in electronics and microelectronics. Particularly suitable for applications such as insulated-gate bipolar transistors (IGBT) and small-outline transistors (SOT), our solders fulfil the highest quality standards.

BRAZETEC pays great attention to the selection of raw materials with a high purity (4N/5N) in order to meet the demanding requirements in power electronics. The excellent quality of the BRAZETEC high purity soft solders ensures reliable and durable solder connections and consequently outstanding performance in your electronic components.

Soft Solder Alloy Properties

Alloy Composition	T _{Solidus} [°C]	T _{Liquidus} [°C]	Density [g/cm ³]
SnAg3Cu0.5	217	223	7.4
SnAg3Cu0.5Co0.1	219	236	7.4
SnAg3.5	221	221	7.4
SnCu3In0.5	226	300	7.4
In	156	156	7.3
InSn50	118	124	7.2
PbAg2.5	304	304	11.2
PbSn4	310	317	11.1
PbSn5	306	315	10.9
PbSn5Ag2.5	300	315	11.1

* Further alloy compositions on request

Purity:

The purity of BRAZETEC soft solder alloys is at least 99,99 % (i. e. maximum 100 ppm metallic impurities).

Standard Delivery Form:

The standard delivery form for soft solders is in the form of tape or perforated tape. Other delivery forms, such as preforms, wire or slugs, are available on request.

BRAZETEC STANDARDS OVERVIEW

Name	ISO 17672	ISO 3677	DIN EN 1044*	AWS A5.8	DIN 8513*	JIS	GB/T
BrazeTec Brazing Alloys, Cadmium free							GB/T 10046
BrazeTec 5662	–	B-Ag56CuZnSnGa-610/630	–	–	–	–	–
BrazeTec 5600	Ag 156	B-Ag56CuZnSn-620/655	AG 102	BAg-7	L-Ag55Sn	BAg-7	BAg56CuZnSn
BrazeTec 5507	Ag 155	B-Ag55ZnCuSn-630/660	AG 103	–	L-Ag55Sn	–	BAg55CuZnSn
BrazeTec 4576	Ag 145	B-Ag45CuZnSn-640/680	AG 104	BAg-36	L-Ag45Sn	BAg-7A	BAg45CuZnSn
BrazeTec 4076	Ag 140	B-Ag40CuZnSn-650/710	AG 105	BAg-28	L-Ag40Sn	BAg-28	BAg40CuZnSn
BrazeTec 3476	Ag 134	B-Cu36AgZnSn-630/730	AG 106	–	L-Ag34Sn	BAg-7B	BAg34CuZnSn
BrazeTec 3076	Ag 130	B-Cu36ZnAgSn-665/755	AG 107	–	L-Ag30Sn	–	BAg30CuZnSn
BrazeTec 2576	Ag 125	B-Cu40ZnAgSn-680/760	AG 108	–	L-Ag25Sn	–	BAg25CuZnSn
BlueBraze 2410	–	B-Cu44AgZnMnSn(Si)-690/750	–	–	–	–	–
BrazeTec 4404	Ag 244	B-Ag44CuZn-675/735	AG 203	–	–	–	BAg44CuZn
BrazeTec 3075	Ag 230	B-Cu38ZnAg-680/765	AG 204	BAg-20	–	BAg-20	BAg30CuZn
BrazeTec 2500	Ag 225	B-Cu40ZnAg-700/790	AG 205	–	–	BAg-20A	BAg25CuZn
BrazeTec 2009	Ag 220	B-Cu44ZnAg(Si)-690/810	AG 206	–	L-Ag20	–	BAg20CuZn (Si)
BrazeTec Copper-phosphorous Brazing Alloys for Copper and Copper-based Materials							GB/T 6418
BrazeTec S 18	CuP286	B-Cu75AgP-645	CP 101	–	–	BCuP-8	BCu75AgP
BrazeTec S 15	CuP 284	B-Cu80AgP-645/800	CP 102	BCuP-5	L-Ag15P	BCuP-5	BCu80AgP
BrazeTec S 5	CuP 281a	B-Cu89PAg-645/815	CP 104	BCuP-3*	L-Ag5P	–	BCu89AgP*
BrazeTec S 2	CuP 279	B-Cu92PAg-645/825	CP 105	–	L-Ag2P	–	BCu92AgP
BrazeTec S 94	CuP 179	B-Cu94P-710/890	CP 203	–	L-CuP6	–	BCu94P
BrazeTec S 93	CuP 180	B-Cu93P-710/820	CP 202	–	L-CuP7	BCuP-2	BCu93P-B
BrazeTec S 92	CuP 182	B-Cu92P-710/770	CP 201	–	L-CuP8	–	BCu92P
BrazeTec S 90	–	–	–	–	–	–	–
BrazeTec S 86	CuP 386	B-Cu86SnP-650/700	CP 302	–	–	–	BCu86SnP

*These standards were superseded by ISO 17672 and are for information only.



Name	ISO 17672	ISO 3677	DIN EN 1044*	AWS A5.8	DIN 8513*	JIS	GB/T
BrazeTec Silver Brazing Alloys for Special Applications							GB/T 10046
BrazeTec 7200	Ag 272	B-Ag72Cu-780	AG 401	BAG-8	L-Ag72	BAG-8	BAG72Cu
BrazeTec 6009	Ag 160	B-Ag60CuSn-600/700	AG 402	BAG-18	-	BAG-18	BAG60CuSn
BrazeTec Brass Brazing Alloys for Special Applications							GB/T 6418
BrazeTec 60/40	Cu 670	B-Cu60Zn(Si)(Mn)-870/900	CU 303	-	L-CuZn40	-	BCu60Zn(Si)(Mn)
BrazeTec 48/10	Cu 773	B-Cu48ZnNi(Si)-890/920	CU 305	RBCuZn-D	L-CuNi10Zn42	BCu-8	BCu48ZnNi(Si)
BrazeTec Brazing Alloys for the Brazing of Carbides							GB/T 10046 or GB/T 6418
BrazeTec 6488	-	B-Ag64CuInNiMn-730 / 780	-	-	-	-	-
BrazeTec 5081	Ag 450	B-Ag50CuZnNi-660 / 705	-	-	-	-	-
BrazeTec 4900	Ag 449	B-Ag49ZnCuMnNi-680 / 705	AG 502	-	-	-	-
BrazeTec 4900 A	-	B-Ag49ZnCuMnNi-670 / 690	-	-	-	-	-
BrazeTec 2700	Ag 427	B-Cu38AgZnMnNi-680 / 830	AG 503	-	-	-	-
BrazeTec 64/Cu	-	B-Ag64CuInMnNi-730/780	-	-	-	-	-
BrazeTec 49/Cu	-	B-Ag49ZnCuMnNi-670/720	-	-	-	-	-
BrazeTec 49/Cu ^{Plus}	-	B-Ag49ZnCuMnNi-670/720	-	-	-	-	-
BrazeTec 49/CuNiFe	-	B-Ag49ZnCuMnNi-670/720	-	-	-	-	-
BlueBraze 2810	-	B-Cu39AgZnMnInNi-680/760	-	-	-	-	-
BlueBraze 28/Cu	-	B-Cu39AgZnMnInNi-680/760	-	-	-	-	-
BlueBraze 28/Cu ^{Plus}	-	B-Cu39AgZnMnInNi-680/760	-	-	-	-	-
BrazeTec 49/NiN	-	B-Ag49ZnCuMnNi-670/720	-	-	-	-	-
BrazeTec Cu/NiN	Cu 110	B-Cu100-1083	CU 101	BCU-1b	L-CU	BCU-1	-
BrazeTec 21/80	-	B-Cu84MnNi-965 / 1000	-	-	-	-	-
BrazeTec 21/68	-	B-Cu87MnCo 980 / 1030	-	-	-	-	-
BrazeTec Copper-based Pastes							GB/T 6418
BrazeTec D 801	Cu 110	B-Cu100-1085	CU 101	BCu-1b	L-Cu	BCu-1	BCu100-B
BrazeTec D 807	CuP 284	B-Cu80AgP-645/800	CP 102	BCuP-5	L-Ag15P	BCuP-5	BCu80AgP
BrazeTec D 810	CuP 182	B-Cu92P-710/770	CP 201	-	L-CuP8	-	BCu92P
BrazeTec D 813	CuP 286	B-Cu75AgP-645	CP 101	-	-	BCuP-8	BCu75AgP
BrazeTec Nickel-based Pastes							
BrazeTec 897	Ni 710	B-Ni76CrP-890	NI 107	BNi-7	L-Ni7	BNi-7	-
BrazeTec 1002	Ni 620	B-Ni82CrSiBFe-970/1000	NI 102	BNi-2	L-Ni2	BNi-2	-
BrazeTec 1135	Ni 650	B-Ni71CrSi-1080/1135	NI 105	BNi-5	L-Ni5	BNi-5	-

*These standards were superseded by ISO 17672 and are for information only.



OUR SERVICES:

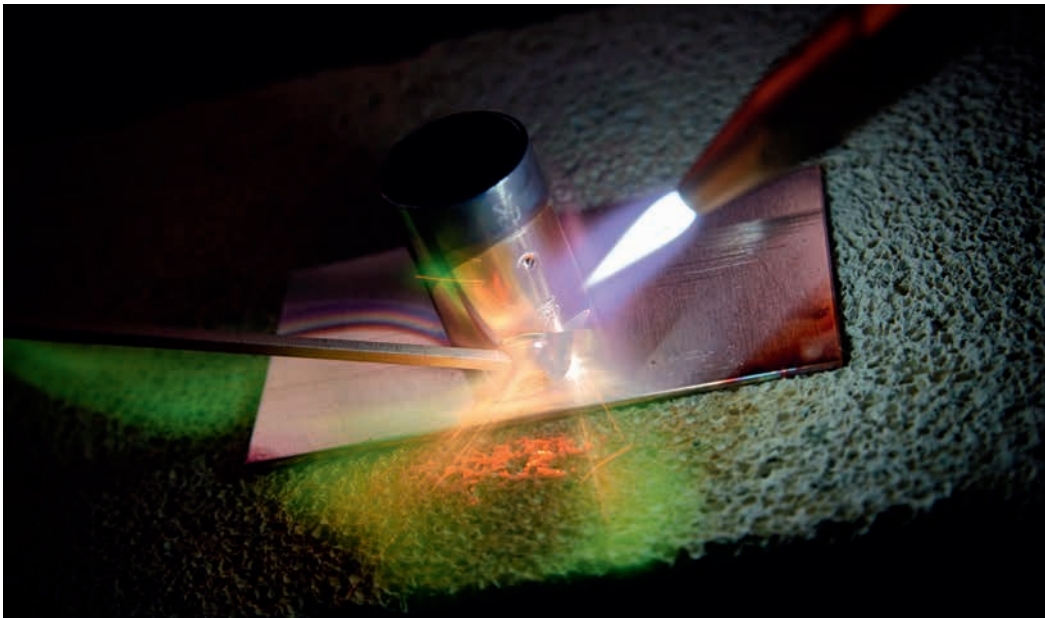
BENEFIT FROM OUR EXPERTISE

From product consulting and brazing analysis to process optimisation and development.
From individual solutions to training your employees: Learn from the industry leader, and optimise your joining technology performance with our expert knowledge.

Brazing Centre: Knowledge Centre and the Basis of all Innovation

We have maintained our competence centre for brazing technology and analytical issues for more than 60 years. Be it a craft enterprise or an industrial company: Make use of our many years of experience, and let us offer you in-depth advice on the finer points of brazing as well as on the use of highly pure materials to help you achieve the maximum optimisation of your production processes.

Whether you are looking for advice on selecting materials, optimising processes or developing specific solutions: Our experienced staff are available to advise and assist you as well as support you on the path to achieving first-class results with our brazing alloy, fluxes, brazing pastes and high purity materials.



Our Services at a Glance

/ Advice on Technical Applications

From refrigeration and air conditioning technology to tooling industry and the transport and electronics industry: we can offer advice on the best choice of products for your processes and the most suitable applications for designing the components you need. If you like, we can also recommend some appropriate heating methods, including the necessary process parameters.

/ Brazing Trials

We can carry out brazing tests on your samples and series components. In the next step, we then evaluate the quality of the brazed connections using the latest analysis methods and compile the results in a detailed assessment. Based on the process parameters which are determined, you will be able to reliably define your individual production parameters.

/ Analytics

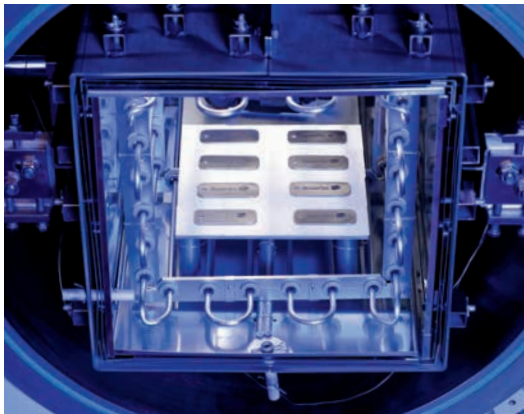
Our modern analytical laboratory has a wide range of different analytical methods that you can use to evaluate your products. Whether component and impurity analysis using ICP or spark spectrometry or DSC analysis to determine melting points, phase transformations and weight changes; BRAZETEC can support you.

Our laboratory also has methods at its disposal for assessing the structure of a material. This can be achieved by characterising the microstructure by microsection or by more intensive micro-range analysis using a microprobe, including EDX/WDX. Powder characterisation and hardness measurements according to Vickers are also included in the service portfolio of our analytical laboratory.



/ Projects in Partnership

Do your development projects involve complex and long-term joining and materials engineering challenges? We'd be pleased to support you – both in optimising existing production and brazing processes and developing new ones. The same applies to individual adaptation of our products to your requirements, and also joint research and development projects.



/ Reliable Analysis and Heating Methods

Thanks to a wide range of analysis and heating methods, our analysis and brazing centre can precisely describe the quality and structure of the brazed connection or the applied brazing layer. Based on the process parameters that are determined, you can reliably define your individual production parameters.

/ Brazing Seminars and Training

Brazing is a complex skill, and it is important to learn how to apply them. We are experts in brazing materials as well as joining technologies, and we are happy to provide your employees with the necessary expertise in joining techniques and practical brazing skills for modern applications engineering.

We will teach you our brazing know-how in

- Group seminars for an entire department at your location.
- In-house training courses for individual employees.
- Customised training courses can be arranged.



Further information can be found at:
www.brazetec.de/dienstleistungen/

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