

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 soldering temperature is clearly visible, the application of additional soft solder may be necessary.

Name	Composition by Weight-%			Melting Range in °C	Alloy according to DIN EN ISO 9453	Flux according to DIN EN ISO 9454	To be used together with	Available Form
	Sn	Ag	Cu					
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	•

* zertifiziert durch DVGW

/ BRAZETEC Soft Solders for Plumbing Technology

The soft solder materials BrazeTec 3 and BrazeTec 4 are in line for copper tube installation according to DVGW. They are supplied

in a handy 250 g coil. BrazeTec Darifix 3 is used mainly in building plumbing.

Name	Composition by Weight-%			Melting Range in °C	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			Tube Material	Fitting Material		Wire	Rods
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 ¹¹	97	-	3	227 - 310	402	soft soldering of copper in construction plumbing (gutters, downpipes, etc.)		BrazeTec Soldaflux® 7000	-	•

¹¹ Delivery form: Rods 12 x 12 x 400 mm


/ BRAZETEC Soldamoll® Special-Soft Solders

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

Name	Composition by Weight-%				Melting Range in °C	Density in g / cm³	Shear Strength in MPa			Electrical Conductivity in m/Ωmm²	DIN EN ISO 9453	Notes on Application	Available Forms			
	Sn	Ag	Cu	Sb			Cu	Ms	S 235				Wire	Rods	Strip	Preforms
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

Some BrazeTec Soldaflux soft solder fluxes are corrosive. For this reason, all flux residues must be removed from the component with water following soldering.

Name	Effective Temperature Range	Type of Residue	Residue soluble in	DIN EN 9454	Notes on Application	Available Form
	in °C					
BrazeTec Soldaflux® 7000	150 – 400	limited corrosive	water	3.1.1.A	carbon steel, non-ferrous-metals, copper tube installation	• 
BrazeTec Slodaflux® A	200 – 400	not corrosive	–	1.1.2.A	copper and copper alloys	•
BrazeTec Soldaflux® K	150 – 450	highly corrosive	water	3.1.1.A	carbon steel, non-ferrous-metals	•
BrazeTec Soldaflux® K 15	200 – 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 steels	•
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 fire proof metal sewing thread, reduces the air permeability without adversely effecting 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 environment of the brazing joint from the burner flame. The 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 GmbH
Konrad-Zuse-Straße 13
63755 Alzenau
Germany

Tel. +49 6023 5071-0

info@brazetec.de
www.brazetec.de

BRAZETEC High Purity Soft Solders



/ 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 power electronics and microelectronics. Particularly suitable for applications such as insulated-gate bipolar transistors (IGBT) and small-outline transistors (SOT), our solders fulfill 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 joints 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.