BRAZETEC

BRAZETEC SOFT SOLDERS AND FLUXES

HEAT PROTECTION MAT AND CLEANING PAD

EIN UNTERNEHMEN DER
Saxonia Gruppe

/ 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	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 approved 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	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 Darifix 3	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'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	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	–	•	•	–	–

Wire · Rods · Strip · Preforms · Flux coated brazing rods · Flux

/ 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 in °C	Type of Residue	Residue soluble in	DIN EN 9454	Notes on Application	Available Form
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® 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.

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