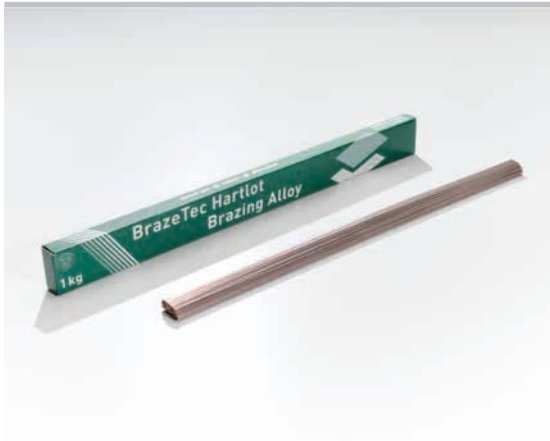






BRAZETEC Brazing Alloys  
for Copper and Copper Based  
Materials





## / BRAZETEC Brazing Alloys for Copper and Copper Based Materials

These brazing alloys can be used at operating temperatures from  $-70\text{ }^{\circ}\text{C}$  to  $+150\text{ }^{\circ}\text{C}$ . The phosphorous containing brazing alloys on this page 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 but should be used with copper alloys. 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. BrazeTec S 2 and BrazeTec S 94 are in line for use according to the DVGW recommendations.

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 $\text{g}/\text{cm}^3$		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 - 835	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	•	-	-	-

 Wire
  Rods
  Strip
  Preforms