Technical Data Sheet BrazeTec BlueBraze 3510U

Standard

Brazing Alloy:	
BrazeTec Standard	
ISO 3677	B-Ag35CuZnMnSn(Si)-680/700
Flux:	
DIN EN 1045	FH 10
AWS A5.31-92R	FB3-F

Brazing Alloy

BrazeTec Standard	
ISO 3677	B-Ag35CuZnMnSn(Si)-680/700
Nominal composition [wt.-%]	Ag 35.0; Cu 32.6; Zn 20.0; Mn 10.0; Sn 2.0; Si 0.4
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025;
Max. impurities [wt.-%]	0.15

Technical data

Melting range acc. ISO 17672	not applicable
Melting range acc. Measurement	approx. 680 - 700 °C (DSC-measurement)
Brazing temperature	min. 700 °C
Density	approx. 8.6 g/cm³
Tensile strength acc. DIN EN 12797	with S235: 320 MPa; with E295: 420 MPa
Elongation at rupture	approx. 14 %
Electrical Conductivity	approx. 2,4 m/ Ωmm²
Shelf life (flux)	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