Technical Data Sheet
BrazeTec S 94

TD TM-BT 0605 E.03

Inhalt

Standard

DIN EN 1044	CP 203 (L-CuP6 acc. DIN 8513)
ISO 3677	B-Cu94P-710/890

Nominal composition [wt.-%]	Cu remainder; P 6,2
Permitted impurities max. [wt.-%]	Al 0,01; Bi 0,030; Cd 0,01; Pb 0,025; Zn 0,05; Zn + Cd 0,05
Max. impurities [wt.-%]	0,25

Technical data

Melting range	approx. 710 - 890 °C (DIN EN 1044)
Working temperature	approx. 760 °C (DIN EN 1044)
Density	approx. 8,1 g/cm³
Tensile strength acc. DIN EN 12797	approx. 250 MPa with Cu
Elongation	approx. 5 %
Operating temp. of brazed joint	max. 150 °C (without loss in strength)

Standard delivery forms*

Wire:	1,0 - 1,5 - 2,0 mm Ø
Rods:	1,0 - 1,5 - 2,0 mm Ø, 500 mm length
Preforms:	rings, shaped parts, sections

*Other delivery forms upon request

Applications

BrazeTec S 94 is a phosphorous-containing brazing alloy with excellent flow characteristics. The brazing alloy is suitable for joining copper to copper or copper-based materials. Due to its phosphorous content, you have not to use an additioal flux for brazing only copper to copper. This brazing alloy is not allowed to be used if sulfur containing medias may have contact with the joint during operating. Further it is not allowed to use this alloy for joining steels (Fe) or materials containing iron,
nickel cobaltas it will be formed brittle phases in the joint.
In refrigeration and air conditioning industries BrazeTec S 94 can be used for service temperatures down to -50°C.
It can be used for brazing with flame, with induction heating and in a furnace under protective atmospheres.
BrazeTec S 94 meets the requirements of the working sheet "GW2" and "GW 7"of DVGW (German association of Gas and Water). It has been awarded by the Gütegemeinschaft Kupferrohr e.V. (The coppertube Manufactures Quality Association).
Typical applications are found e.g. in the plumbing trade, in the electric industry and for the refrigeration and air conditioning industry.