

## Technical Data Sheet BrazeTec 3

### Standard

Alloy-No. acc. ISO 9453 402  
(ISO 3677) (Sn97Cu3)

### Nominal composition [wt.-%]

Permitted impurities max. [wt.-%] Sn remainder; Cu 3  
Pb 0.10; Sb 0.10; Bi 0.10; Au 0.05; In 0.10; Ag 0.10; Al 0.001;  
As 0.03; Cd 0.002; Fe 0.02; Ni 0.01; Zn 0.001

### Technical data

Melting range approx. 227 - 310°C  
Density approx. 7.3 g/cm<sup>3</sup>  
Shear strength acc. DIN EN 12797 with S235: 25 MPa; with Cu 30 MPa; with Ms 20 MPa  
Electrical Conductivity approx. 7.5 m/Ωmm<sup>2</sup>

### Standard delivery forms\*

Wire: 2.0 - 3.0 mm Ø, 250 g spools

\*Other delivery forms upon request

### Applications

BrazeTec 3 is a soft solder free of Antimony and Lead for joining copper tubes for cold and hot water. Suitable parent metals to be joined are copper, brass and red brass. It can be used for soldering with a flame, with resistance heating and with soldering iron. Typical applications are found e.g. in the plumbing industry.

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