

Technical Data Sheet BrazeTec CoMet 2577U

Standard

BrazeTec Standard
(ISO 3677)

(B-Cu37ZnAgMnNi 630/800)

Flux:

DIN EN 1045

FH10

Brazing Alloy

Nominal composition [wt.-%]

Ag 24,5; Cu 37,2; Zn 33,5; Ni 2; Mn 2; Si max. 0,3

Permitted impurities max. [wt.-%]

Al 0,001; Bi 0,030; Cd 0,010; P 0,008; Pb 0,025

max. impurities [wt.-%]

0,3

Technical data

Melting range

approx. 630 - 800 °C

Working temperature

approx. 770 °C

Density

approx. 8,47 g/cm³

Operating temp. of brazed joint

approx. -200 °C to +200 °C (without loss in strength)

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 mm Ø, 500 mm length

*Other delivery forms upon request

Applications

BrazeTec CoMet 2577U is a flux coated low melting silver based brazing alloy with excellent flow characteristics. It is an especially developed brazing alloy for avoiding a liquid metal embrittlement during brazing galvanized or naked steel tubes in the refrigeration- and air conditioning industry. But it is also suitable for brazing any other steels, copper and copper based alloys as well as for nickel and nickel based alloys.

It can be used for brazing with flame.

Typical applications are found e.g. in the electric and automotive 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

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