

Technical Data Sheet BrazeTec BlueBraze 3010U

Standard

Brazing Alloy:
BrazeTec Standard
ISO 3677

B-Cu38AgZnMnSn(Si)-690/730

Flux:

DIN EN 1045
AWS A5.31-92R

FH 10
FB3-F

Brazing Alloy

Nominal composition [wt.-%]
Permitted impurities max. [wt.-%]
Max. impurities [wt.-%]

Ag 30.0; Cu 37.8; Zn 20.0; Mn 10.0; Sn 2.0; Si 0.2
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025;
0.15

Technical data

Melting range acc. ISO 17672
Melting range acc. Measurement
Brazing temperature
Density
Tensile strength acc. DIN EN 12797
Electrical Conductivity
Shelf life (flux)

not applicable
approx. 690 - 730 °C (DSC-measurement)
min. 730 °C
approx. 8.4 g/cm³
with S235: 350 MPa; with E295: 430 MPa
approx. 2.4 m/Ωmm²
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 3010U 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

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