# Technical Data Sheet BrazeTec CSH 610 TD

**Solvent based brazing paste**
BrazeTec CSH 610 TD is especially developed for the copper-brass radiator brazing process (CuproBraze). It is especially designed for brazing the tube-to header joints and can be applied by so called slurry machines. The binder system is solvent based and ensures fast drying, good adhesion and a residue free burnout under protective atmosphere.

**Standard**
**Brazing alloy**

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| BrazeTec Standard | CPO 610 |

**Filler**

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| BrazeTec Standard | CuP8 |

**Nominal composition [wt.-%]**

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| Brazing alloy | Cu Rem.; Sn 9.3; P 6.5; Ni 5.7 |
| Filler | Cu Rem.; P 8.3 |
| Permitted impurities max. [wt.-%] | Al 0.010; Bi 0.030; Cd 0.010; Pb 0.025; Zn 0.050; Zn + Cd 0.050 |

**Technical data**

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| Melting range of brazing alloy | approx. 595 - 620 °C |
| Working temperature | approx. 650 °C |
| Metal content | > 80 wt.-% |
| Flux content of the brazing paste | < 3 wt.-% |
| Density of brazing paste | approx. 3,2 g/cm³ (20 °C) |
| Grain size of brazing alloy powder | < 106 µm |
| Viscosity | 9 ± 1.5 Pa s (Cone-Plate; 150 µm; D= 1/s; 20 °C) |
| Drying temperature | about 100 - 120 °C at work piece |
| Cleaning agent | BrazeTec Cleaning Agent TD |
| Shelf life | min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C stir well before use |

**Packaging**

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| Standard | 10; 25 kg |

**Applications**
BrazeTec CSH 610 TD is applied by special equipment (slurry machines) on the header plates. Drying takes place at temperatures between 100 °C and 120 °C at the header plate. The paste is suitable to braze wider gaps between the tubes and the header plate.
The brazing process has to be carried out in protective atmosphere using nitrogen at a brazing temperature of about 650 °C depending on brazing furnace, furnace cycle, size of parts etc.