

Technical Data Sheet BrazeTec CSO 610.2 TD

Solvent based brazing paste

BrazeTec CSO 610.2 TD is especially developed for the copper-brass radiator brazing process (CuproBraze). It is especially designed for brazing the tank-to header joints. The binder system is solvent based and ensures a good adhesion and a residue free burnout under protective atmosphere.

Standard

BrazeTec Standard CPO 610

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Cu Rem.; Sn 9.3; P 6.5; Ni 5.7

Al 0.010; Bi 0.030; Cd 0.010; Pb 0.025;

Zn 0.050; Zn + Cd 0.050

Technical data

Melting range of brazing alloy	approx. 595 - 620 °C
Working temperature	approx. 650 °C
Metal content	approx. 90 wt.-%
Flux content of the brazing paste	< 3 wt.-%
Grain size of brazing alloy powder	< 90 µm
Viscosity	560 ± 60 Pa s (Cone-Plate; 150 µm; D= 0.5/s; 20 °C)
Flash point of solvent	approx. 73 °C
Evaporation temperature of binder	approx. 180 - 420 °C at 1 bar
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

Standard 25 kg

Applications

BrazeTec CSO 610.2 TD is applied by air pressure or screw dispenser techniques on the gap between tank and header plates. Drying takes place at temperatures between 100°C and 120°C at the base material. 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.

Best brazing results are achieved when the air inside the tanks has been replaced by nitrogen prior to brazing.

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