



Technical Data Sheet

BrazeTec S 15



TD BT 0602 E.01

Standard

CP 102 acc. DIN EN 1044 (L-Ag15P acc. DIN 8513)
B-Cu80AgP-650/800 acc. ISO 3677

Nominal composition in wt.-% Cu remainder; Ag 15; P 5

Permitted impurities (weight-%):

Al 0,01; Bi 0,030; Cd 0,025; Pb 0,025; Zn 0,05; Zn + Cd 0,05; Total impurities 0,25

Technical data

Melting range	app. 645 - 800 °C	(DIN EN 1044)
Working temperatur	app. 700 °C	(DIN EN 1044)
Density	app. 8,4 g/cm ³	
Tensile strength acc. DIN 8525	with Cu: 250 MPa	
Elongation	app. 10%	
Electrical Conductivity	app. 7,0 m/ Ωmm ²	
Operating temperature of brazed joint	max. 150 °C (without loss in strength)	

Standard delivery form*

Wire: 1,0 - 1,5 - 2,0 mm Ø

Rods: 1,5 - 2,0 - 3,0 mm Ø, 500 mm length

Ribbon: 0,1/ 0,2/ 0,3/ 0,4 mm thickness and 70 mm width

Preforms: rings, shaped parts, sections, stamped and shaped parts, lamina, discs, perforated plates

*Other delivery forms on request

Application

BrazeTec S 15 is a phosphorous-containing brazing alloy with good flow characteristics. The brazing alloy is suitable for joining copper to copper or copper-based materials. Due to its phosphorous content, you have not to use an additional flux for brazing only copper to copper. This brazing alloy is not allowed to be used if sulfur containing medias may have contact with the joint during operating. Further it is not allowed to use this alloy for joining steels (Fe) or materials containing iron, nickel and cobalt as brittle phases will be formed in the joint.

In refrigeration and air conditioning industries BrazeTec S 15 can be used for service temperatures down to -50°C.

It can be used for brazing with flame, with induction heating and in a furnace under protective atmospheres.

Typical applications are found e.g. in the electric industry and for the refrigeration and air conditioning industry.

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