



Technical Data Sheet BrazeTec S 93



TD BT 0606 E.01

Standard

CP 202 acc. DIN EN 1044 (L-CuP7 acc. DIN 8513)
B-Cu93P-710/820 acc. ISO 3677

Nominal composition in wt.-% Cu remainder; P 7

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. 710 - 820 °C	(DIN EN 1044)
Working temperature	app. 730 °C	(DIN EN 1044)
Density	app. 8,05 g/cm ³	
Tensile strength acc. DIN 8525	with Cu: 250 MPa	
Elongation	app. 5 %	
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
Preforms: rings, shaped parts, sections
*Other delivery forms on request

Application

BrazeTec S 93 is a phosphorous-containing brazing alloy with excellent 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 93 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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