# Technical Data Sheet BrazeTec BlueBraze 2410U

**Standard**

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| Brazing Alloy: | |
| BrazeTec Standard | |
| ISO 3677 | B-Cu44AgZnMnSn(Si)-690/750 |
| | |
| Flux: | |
| DIN EN 1045 | FH 10 |
| AWS A5.31-92R | FB3-F |

**Brazing Alloy**

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| **Nominal composition [wt.-%]** | Ag 24.0; Cu 43.7; Zn 20.0; Mn 10.0; Sn 2.0; Si 0.3 |
| Permitted impurities max. [wt.-%] | Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; |
| Max. impurities [wt.-%] | 0.15 |

**Technical data**

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| Melting range acc. ISO 17672 | not applicable |
| Melting range acc. Measurement | approx. 690 - 750 °C (DSC-measurement) |
| Brazing temperature | min. 750 °C |
| Density | approx. 8.4 g/cm³ |
| Tensile strength acc. DIN EN 12797 | with S235: 330 MPa; with E295: 480 MPa |
| Elongation at rupture | approx. 17 % |
| Electrical Conductivity | approx. 2,4 m/ Ωmm² |
| Shelf life (flux) | min. 6 months, but only at storage temperatures between +5 to +30 °C. Avoid rapid changes in temperature |

**Standard delivery forms***

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| Rods: | 1.5 - 2.0 mm Ø, 500 mm length |

*Other delivery forms upon request

**Applications**

BrazeTec BlueBraze 2410U 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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