

## Technical Data Sheet BrazeTec BlueBraze 3510

### Standard

BrazeTec Standard  
ISO 3677

B-Ag35CuZnMnSn(Si)-680/700

### Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

Ag 35.0; Cu 32.6; Zn 20.0; Mn 10.0; Sn 2.0; Si 0.4  
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025;  
0.15

### Technical data

Melting range acc. ISO 17672

not applicable

Melting range acc. Measurement

approx. 680 - 700 °C (DSC-measurement)

Brazing temperature

min. 700 °C

Density

approx. 8.6 g/cm<sup>3</sup>

Tensile strength acc. DIN EN 12797

with S235: 320 MPa; with E295: 420 MPa

Shear strength acc. DIN EN 12797

With S235

min. 150 MPa

Elongation at rupture

approx. 14 %

Electrical Conductivity

approx. 2,4 m/ Ωmm<sup>2</sup>

### Standard delivery forms\*

Wire:

1.5 - 2.0 mm Ø

Rods:

1.5 - 2.0 mm Ø, 500 mm length

Strip:

0.1/ 0.2/ 0.25 / 0.3/ 0.4 mm thickness and 1.5 to 70 mm width

Preforms:

rings, shaped parts, sections

\*Other delivery forms upon request

### Applications

BrazeTec BlueBraze 3510 is a 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.

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