



TD BT 1201 E.02

Standard

Soldering alloy	S-Sn97Cu3 nach DIN EN 29453 S-Sn97Cu3 nach ISO 3677
Flux	Type 3.1.1. acc. DIN EN 29454-1

Composition

Soldering alloy [wt.-%]:	Sn remainder; Cu 3
Permitted impurities [max. wt.-%]:	Pb 0,1; Sb 0,05; Bi 0,1; Cd 0,002; In 0,05; Ag 0,05; Al 0,001; As 0,03; Fe 0,02; Zn 0,001
Total impurities [max. wt.-%]:	0,2
Flux:	zincchloride, ammoniumchloride, organic binder

Technical Data

Melting temperature range of alloy	app. 230 - 250°C
Alloy content	min. 60% (DVGW, GW 7)
Chlorine content	max. 9% (DVGW, GW 7)
Colour	grey
Density	app. 2,4 g/cm ³
Viscosity	300 - 500 dPas (Haake Viskotester VT02; 18 - 22°C)
Flux residues	corrosive; water-soluble
Shelf life	min. 6 months in the original locked container storage temperature +5 to +30°C

Packing 250 g jar with brush

Application

BrazeTec Degufit 3000 is a soft soldering paste for plumbing meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German association of Gas and Water). It is approved and registered by DVGW and has been awarded by the Gütegemeinschaft Kupferrohr e.V. (The copper tube Manufacturers Quality Association). Therefore it is suitable for plumbing copper tubes with fittings for potable water lines. It can be worked with flame or with resistant soldering clamps, too. The brush makes it easier to apply the paste on the copper tube in a thin layer and prevents an unwished contact with the skin. Prior to applying the paste the soldering areas have to be cleaned e.g. with a BrazeTec cleaning pad (metal free).

Besides the plumbing of tubes the paste can be used for soldering steel, copper, copper alloys, nickel and nickel alloys.

Note for the user

The paste has to be applied to the cleaned end of the tube in a thin layer. After you have put the tube end into the fitting it will be heated with flame or resistant soldering clamps till you will see a fillet. Than soldering alloy will be fed to the joint by a wire of BrazeTec 3.

After soldering the paste residues have to be removed. This can be done by wiping or washing on the outer surfaces with a wet cloth. Potable water lines have to be rinsed referring DIN 1988 in.

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