

Technical Data Sheet BrazeTec Degufit 3000

Standard

Alloy-No. acc. ISO 9453
 ISO 3677
 ISO 9454:2016

402 (Alloy)
 Sn97Cu3 (Alloy)
 Type 3.1.1.4 (Flux)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Sn remainder; Cu 3
 Pb 0.10; Sb 0.10; Bi 0.10; Au 0.05; In 0.10; Ag 0.10; Al 0.001;
 As 0.03; Cd 0.002; Fe 0.02; Ni 0.01; Zn 0.001

Technical data

Colour	grey
Melting range	approx. 227 - 310 °C
Metal content	min. 60 wt.-%
Chloride content	max. 9%
Density of soldering alloy	approx. 7,3 g/cm ³
Density of soldering paste	approx. 2,4 g/cm ³ (20 °C)
Viscosity	300 - 500 dPa s (Haake Viscotester 02, Sp.2, 20 ±2 °C)
Residues	corrosive, soluble in water
Cleaning agent	Water
Shelf life	min. 24 months, but only in the original sealed container at storage temperatures between +5 to +30°C stir well before use

Packaging

Standard 250 g jar with brush

Applications

BrazeTec Degufit 3000 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.

Further comments

The paste must 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.

Then soldering alloy will be fed to the joint by a wire of BrazeTec 3.

After soldering the paste residues must 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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