FELDER seit 1979 LÖTTECHNIK

Product Information

Brass Brazing Alloy Cu 670

Acc. EN ISO 17672, CU 303 – EN 1044, B-Cu60Zn(Si)(Mn)-870/900 – EN ISO 3677
For brazing steel and galvanised steel plates, copper, nickel and cast iron

Brass Brazing Alloy “blank“, bare without flux
Brass Brazing Alloy “UM“(flux coated) resp. “G“ (flux filled), flux type FH 21- EN ISO 18496 (former EN 1045)

Item No.: 3000..../3001...../3002....

Description

Brass brazing alloy with excellent strength for soldering of steel and galvanised steel plates, copper, nickel as well as casting materials and as autogenous additive for the welding of brass and bronze.

Properties

Our brass brazing alloy is characterised by particularly good flow properties. Due to the Mn-, Si- and Sn- content the tendency to corrosion is significantly reduced. Furthermore, cracking is also prevented. With galvanised steel plates, the zinc flows back right up to the soldered seam after taking away the flame so that in the heat zone an optimal corrosion protection is guaranteed.

Composition (%): (Cu 670 - DIN EN ISO 17672)	Cu	58.5 - 61.5
	Si	0.15 - 0.4
	Mn	0.05 - 0.25
	Sn	<0.20
	Zn	rest
Working temperature:	approx. 900 °C	
Melting range:	870 °C – 900 °C	
Tensile strength:	350 - 400 N/mm^2	
Density:	8,4 g/cm^3	

Application Field

For brazing of steel, galvanised steel plates, casting materials, copper, nickel. The brazing joints are applicable with operating temperatures up to 400 °C. In addition, our **Brass Brazing Alloy Cu 670** is excellently suitable for welding brass and bronze.

Application Advice

The brazing area must be free of oxide layers, tinder, dross and greases. When using blank rods, we recommend using the **FELDER Brazing Flux Paste (or Powder) "UNIVERSAL"**.

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When using flux-coated material (**Brass Brazing Alloy "UM**"):
Pre-heat the work piece up to approx. 400 °C, apply brazing rod and let the flux melt off, then heat up to working temperature and let the solder melt off. The flame of the burner should be adjusted neutral. The flux residues must be removed thoroughly with water.
When using flux-cored material (**Brass Brazing alloy "G**"):
Directly heat-up the work piece to working temperature, apply brazing rod and let melt off. The flux residues must be removed thoroughly with water.

Delivery Forms

Delivery forms	Dimensions
500 mm rods, bare	Ø 2.0 mm
	Ø 2.5 mm
	Ø 3.0 mm
1000 mm rods, bare	Ø 2.0 mm
	Ø 5.0 mm
	Ø 6.0 mm
500 mm rods, flux coated	Ø 2.0 mm
	Ø 2.5 mm
	Ø 3.0 mm
	Ø 4.0 mm
500 mm rods, flux cored	Ø 2.5 mm

Further Information

Protect against humidity.

 Status: 04/24

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