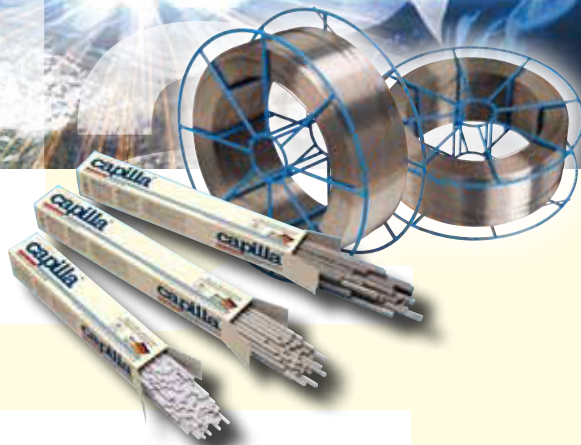


capilla®

Part catalogue



**7. Filler material
for brazing and
soldering**

7 Filler material for brazing and soldering

Designation	DIN EN 1044	DIN EN ISO 3677	(DIN 8513)	Solidus/Liquidus [°C]	Working temperature [°C]	Tensile strength of fusion zone [daN/mm ²]*	Flux DIN EN 1045
Ag-solder							
capilla® AG 102F / AG 102	AG 102	B-Ag56CuZnSn	L-Ag55Sn	620 - 655	655	45	FH 10
capilla® AG 103F / AG 103	AG 103	B-Ag55ZnCuSn	L-Ag55Sn	620 - 660	660	40	FH 10
capilla® AG 104F / AG 104	AG 104	B-Ag45ZnCuSn	L-Ag45Sn	640 - 680	670	40	FH 10
capilla® AG 105F / AG 105	AG 105	B-Ag40CuZnSn	L-Ag40Sn	640 - 700	690	36	FH 10
capilla® AG 106F / AG 106	AG 106	B-Cu36AgZnSn	L-Ag34Sn	630 - 730	710	43	FH 10
capilla® AG 107F / AG 107	AG 107	B-Cu36ZnAgSn	L-Ag30Sn	650 - 750	740	38	FH 10
capilla® AG 502F / AG 502	AG 502	B-Ag49ZnCuMnNi	L-Ag49	680 - 705	690	30	FH 10
capilla® AG 203F / AG 203	AG 203	B-Ag44CuZn	L-Ag44	675 - 735	730	45	FH 10
capilla® AG 206F / AG 206	AG 206	B-Cu44ZnAg(Si)	L-Ag20	690 - 810	810	40	FH 10
Brass solder							
capilla® CU 303F / CU 303	CU 303	B-Cu60Zn(Si)(Mn)	L-CuZn40	890 - 900	900	40	FH 21
capilla® CU 306F / CU 306	CU 306	B-Cu60ZnSn(Ni)(Si)(Mn)	L-CuZn39Sn	870 - 890	900	42	FH 21
capilla® CU 305F / CU 305	CU 305	B-Cu48ZnNi(Si)	L-CuNi10Zn42	890 - 920	910	45	FH 21
Al-solder							
capilla® AL 104F / AL 104	AL 104	B-Al88Si	L-AlSi12	575 - 585	590	15	FL 20

Due to the fact, that mechanical properties of the fusion zone are dependent on the properties of the base material, technical data are standard values.

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