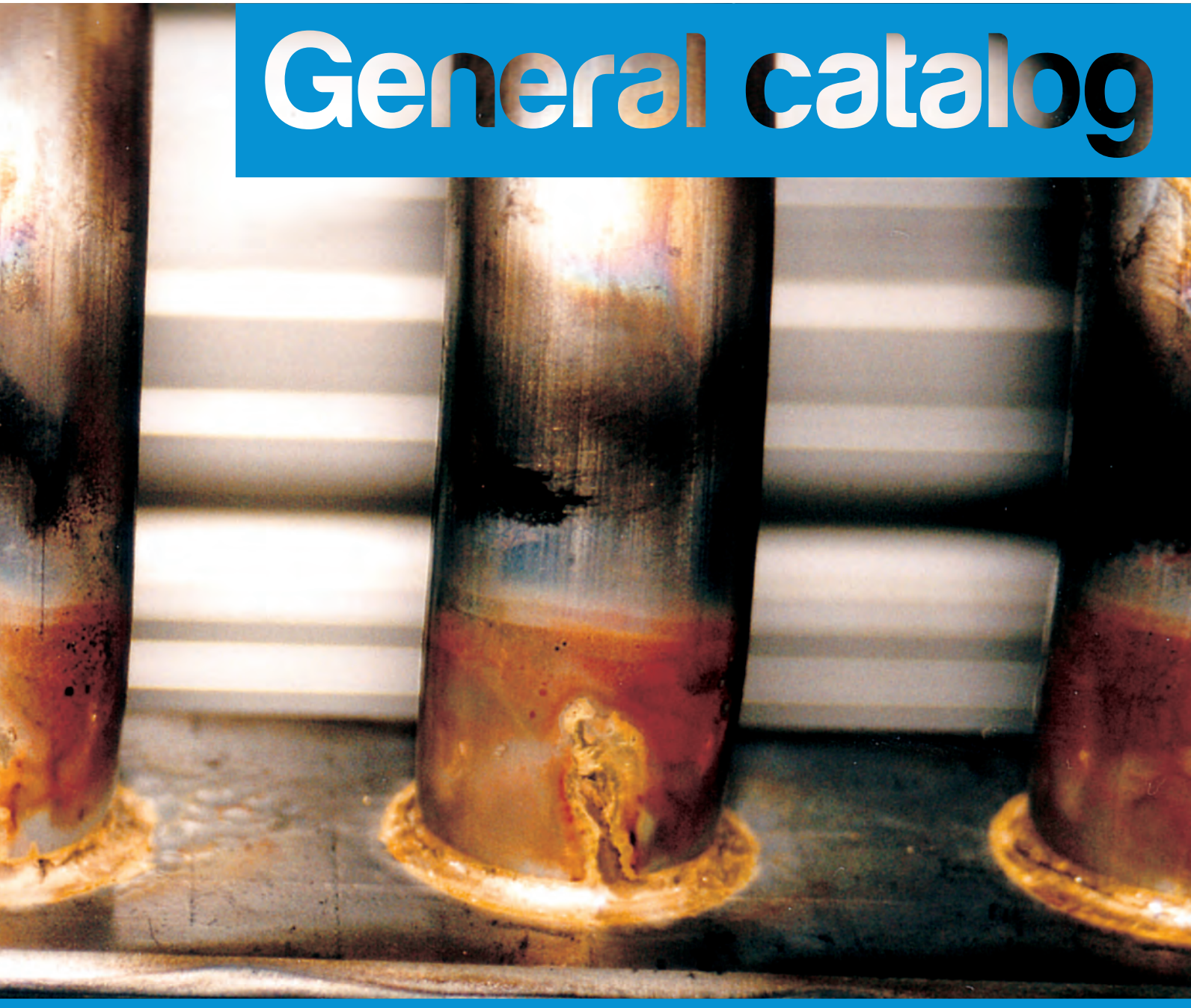
General catalog



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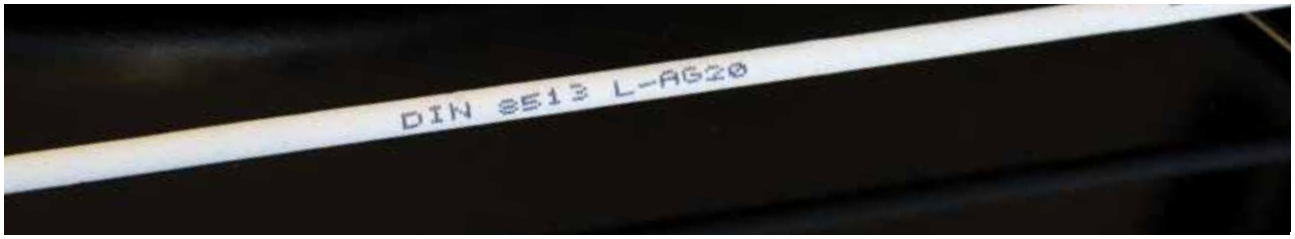
Index

Silver

Silver alloys Cd free - Coated Silver alloys Cd free

CODE	COMPOSITION %				MELTING RANGE	EN 1044 ISO 17672	RECOMMENDED FLUX	APPLICATIONS
	Ag	Cu	Zn	Others				
T28	5	55	40	-	820-870	AG 208 Ag 205	D31 D60 D31F DKM	Alloys for double welding, very tough and resistant, excellent for brass strips
T29	12	48	40	-	800-830	AG 207 Ag 212		
T68	20	45	35	-	690-810	AG 206 -		
T77	25	40	35	-	700-790	AG 205 Ag 225		
T77S	25	40	33	Sn2	680-760	AG 108 Ag 125	D4 D26N D31 D31F D39 D60 D70 DKM	Alloys Cadmium Free with medium / high Silver contents, small melting range, excellent capillarity and fluidity. Used for brazing joints such as diaphragms, thermostats, etc. Indicated for food contiguous point
T79	30	38	32	-	680-765	AG 204 Ag 230		
T79S	30	36	32	Sn2	665-755	AG 107 Ag 130		
T80S	34	36	27	Sn3	630-730	AG 106 Ag 134		
T90S	40	30	28	Sn2	650-710	AG 105 Ag 140		
T96S	45	27	25	Sn3	640-680	AG 104 Ag 145		
T97	44	30	26		675-735	AG 203 Ag 244		
T99S	55	21	22	Sn2	630-660	AG 103 Ag 155		
T99	56	22	17	Sn5	620-655	AG 102 Ag 156		
T600	60	26	14	-	695-730	AG 202 -		
T700	67	22	11	-	700-730	-		
T720	72	28		-	780	AG 401 Ag 272		
T750	74	18	8	-	740-780			
T500	49	16	23	7,5Mn-4,5Ni	625-705	AG 502 Ag 449	D26 DKBLACK	Special alloys for hard metals or where a greater wet ability of the joint is needed
T530	49	27	21	2,5Mn-0,5Ni	680-705	-		
Trimetallico Z	49	27	21	2,5Mn-0,5Ni	670-690	-		



Brass - MR serie Brass

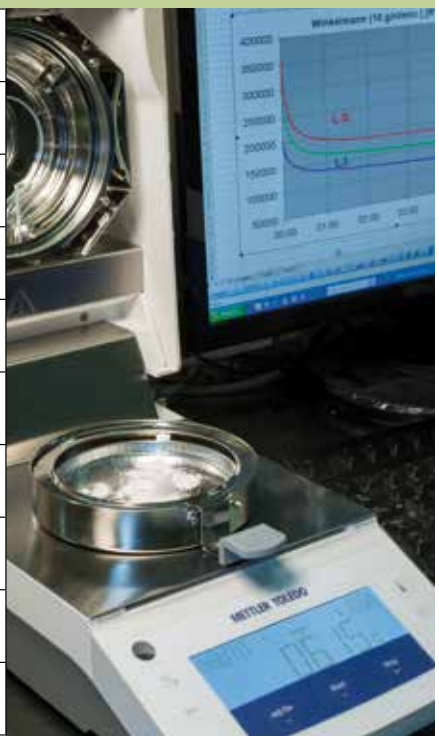
CODE	COMPOSITION %					MELTING RANGE	EN 1044 ISO 17672	RECOMMENDED FLUX	APPLICATIONS
	Cu	Zn	Ni	Si	others				
S21	59,5	Bal.	-	0,25	-	875 - 895	CU 301 Cu 470a	D50 DB D51 D54 DL87N DL87 Special DL88N DL90N DL89N DL89ECO DL88ECO DL87ECO ECOFLUX ECOFLUX MEDIUM	MR alloys used in combination with flux in the flame through the vaporizer system, they gain greater fluency and penetration into the joint, leaving irrelevant residues of flux after the brazing operations
SM23	59	Bal.	-	0,15	Mn 0,8 Sn 1	880-900	-		
ST22	59	Bal.	-	0,25	Sn1	800 - 840	-		
SN32	57	Bal.	5	0,15	-	860 - 910	-		
SN34	51	Bal.	10	0,2	-	900 - 930	- Cu 773		
SN36	49,9	Bal.	9	0,15	-	890 - 920	CU 305 Cu 773		
SN37A	48	Bal.	9,5	0,15	Ag1	870 - 900	-		




Brass

Fluxes for silver brazing

CODE	SUPPLY CONDITION	EN 1045	MELTING RANGE	APPLICATIONS
D 4	Powder - Paste	FH 10	550 - 850	Active Flux very fluid, suitable for Silver low temperature alloy and restricted melting range
D 26 N	PPowder - Paste	FH 10	550 . 800	General pourpose flux suitable for Silver alloys, with average smoothness and good resistance to the flame
D 32 N	Powder	FH 10	550 - 800	High temperature flux ideal for special applications such as brazing furnaces that require long-term resistance to heat
DK BLACK	Paste	FH 10	550 - 850	Flux for special application, such as hard metals and steels, requiring a higher wet ability of the joint
D39LH	Liquid	FH 10	550 - 800	Water solution liquid Flux, suitable for low temperature welding or low flame resistance, negligible residues are present
D 60	Paste	FH 20	600 - 1000	Flux with excellent resistance to high temperature for general purposes
D 70	paste	FH 20	600 - 980	High Temperature Flux with goods heat resistance with greater smoothness of D60M from which derives
DKM	paste	FH 10	550 - 800	General purpose flux for medium/high temperatures in in smooth paste
D 31 F	Powder - Paste	FH 10	600 - 900	Medium/high temperatures flux with an excellent flame resistance



Fluxes for brass brazing

CODE	SUPPLY CONDITION	EN 1045	MELTING RANGE	APPLICATIONS
D51A	Powder - Paste	FH21	700 - 1100	High temperature Brazing flux for carbon steel join, or copper carbon steel join
D54	Paste	FH21	700 - 1100	

Dosable Fluxes

CODE	SUPPLY CONDITION	EN 1045	MELTING RANGE	APPLICATIONS
D 10 M	Dosing Paste	-	95 - 425	Flux for tender alloys
D 12 M	Dosing Paste	-	160 - 300	
D 32 M	Dosing Paste	FH 21	550 - 800	
D 53 M	Dosing Paste	FH 20	780 - 950	Dosing Flux for Brass alloys
D 50 M	Dosing Paste	FH 20	700 - 1100	

HDROFLUX

HARDFLUX BRASSFLUX

FLUIDYFLUX BASICFLUX BLACKFLUX

FLUX

Liquid Flux

Liquid Flux

CODE	CONCENTRATION	EN 1045	APPLICATIONS	PACKAGING
L 80 N	Low	FH 21	For microflames	Tanks Plastic Homologated 5 Lt. Tanks Plastic Homologated 10 Lt. Tanks Plastic Homologated 20 Lt. Tanks Metal Homologated 25 Lt. Tanks metal Homologated 200 Lt.
L 80/15 N	Low	FH 21		
L 84 N	Low	FH 21		
L 85 N	Low	FH 21		
L 86 N	Medium	FH 21	For hydrogen machines Goldsmith Industry	
L 86 A	Medium	FH 21		
L X N	Medium	FH 21		
L X A	Medium	FH 21		
L 87 N	Medium	FH 21		
L 87 Special	Medium / High	FH 21	Metal furnishings – Refrigerator– Goldsmith Industry	
L 88 N	Medium / High	FH 21		
L 90 N	High	FH 21		
L 89 N	High	FH 21		
L 90 A	High	FH 21	low fume liquid flux	

ECOFLUX Liquid Flux ®

CODICE	CONCENTRATION	EN 1045	APPLICATIONS	PACKAGING
ECOFLUX®	High	FH 21	Metal Furnishings Refrigeration Air Conditioning Jewelry Industries	Tanks Plastic Homologated 5 Lt. Tanks Plastic Homologated 10 Lt. Tanks Plastic Homologated 20 Lt. Tanks Metal Homologated 25 Lt. Tanks Metal Homologated 200 Lt.
ECOFLUX® MEDIUM	Medium / High	FH 21		
ECOFLUX®89	High	FH 21	Metal Furnishings Refrigeration Air Conditioning Jewelry Industries	
ECOFLUX®88	Medium / High	FH 21		
ECOFLUX®87	Medium	FH 21	Hydrogen Machines Jewelry Industries	

ECOFLUX®

Copper Phos alloys

CODE	COMPOSITION %				MELTING RANGE	EN 1044 ISO 17672	RECCOMANDED FLUX	APPLICATIONS
	Ag	Cu	P	Sn				
FH51	-	94	6	-	710 - 890	CP 203 CuP 179	Not necessary for Cu/Cu For brass/Cu joint D39LH D60 D4 D31 D26	Copper Phosphorus alloys, Copper Phosphorus Tin alloys, Copper Phosphorus Silver based alloys. Suitable for brazing copper-copper, copper-brass, with the flux, mostly used in conditioning and plumbing
FH52	-	93,2	6,8	-	710 - 820	CP 203 CuP 180		
FH49	-	93	7	-	710 - 793	CP 202 CuP 181		
FH50	-	92	8	-	710 - 770	CP 201 CuP 182		
FH55	-	86	7	7	650 - 700	CP 302 CuP 386		
FH47	0,4	93	6,6	-	710 - 820	-		
FH48	2	91,5	6,5	-	650 - 810	CP 105 CuP 279		
FH45	5	89	6	-	650 - 810	CP 104 CuP 284		
FH46	6	87	7	-	645 - 725	-		
FH35	15	80	5	-	650 - 800	CP 102 CuP 284		
FH32	18	75	7	-	645 - 670	CP 101 CuP 286		

Aluminum alloys

CODE	COMPOSITION %				MELTING RANGE	EN 1044 ISO 17672	RECCOMANDED FLUX	AVAILABILITY	APPLICATIONS
	Al	Si	Mg	Zn					
ALL95	95	5	-	-	566 - 630	AL101 Al105	AL 130	wire-rods	Aluminum brazing
ALL87	88	12	-	-	575 - 585	AL104 Al112		wire-rods-powder	Aluminum brazing
ALL MG5	94,7	0,3	5		566 - 650	-		wire-rods	Aluminum manganese brazing
ALL99	99,5	0,5	-		660	-		wire-rods	Tig welding
ALL84S	22		-	72	397 - 483	-	Flux not necessary because it is in the alloy	Cored flux wire-rods	Low temperature brazing Al-Al, Al-Cu, Al-Inox
ALL86S	90	10	-		575 - 585	AL103 Al 110		Cored flux wire-rods	Low temperature brazing
ALL87S	88	12	-		575 - 585	AL104 Al 112			

Aluminum fluxes

CODE	SUPPLY CONDITION	EN 1045	MELTING RANGE
AL 130	Powder/Paste	FL 10	550 - 650
AL 140	Powder	FL 20	550 - 650
AL 160	Powder – dosing paste spry for CAB furnace	FL 20	515 - 630
AL 130 M N WS	Low corrosive dosing paste	FL 10	550 - 650
AL 140 CS	Cs bass flux for low temperature	FL 20	450 - 600

Other alloys

Soldering

CODE	COMPOSITION %			MELTING RANGE	APPLICATIONS
	Sn	Pb	Others		
ST60	60	40	-	183 - 188	Tin-lead based alloy
ST100	100		-	242	Pure tin
ST130	96,5	-	Ag 3,5	221	Tin Silver based alloy
ST150	95	-	Ag 5	225 - 245	
ST124	99	-	Cu 1	230 - 240	Tin copper based alloy, used as Pb alternative
ST125	97	-	Cu 3	230 - 250	

Soldering fluxes

CODE	SUPPLY CONDITION	MELTING RANGE	APPLICATIONS
D 14S	Liquid	95 - 425	Soldering acid flux for common uses
D 14X	Liquid	95 - 425	Soldering acid flux for stainless steel
D 10L	Liquid	95 - 425	Low acidity solder flux
D 15N	Liquid	160 - 300	Electronic solder flux
D 10 M	Dosing Paste	95 - 425	Electronic solder flux
D 12 M	Dosing Paste	160 - 300	low corrosive dosing flux for soldering

Alloy reference tables

Silver alloys Cd free

CODE	CHEMICAL COMPOSITION													MELTING RANGE	BRAZING TEMPERATURE	EN 1044 ISO 17672	TYPICAL APPLICATIONS	TENSILE STRENGTH (N/MM²)
	Ag	Cu	Zn	P	Si	Sn	Ni	Cr	B	Al	Mn	Mg	Fe					
T28	5	55	40											820 870	860	AG 208 Ag 205	Double brazing , Fe/Fe Fe/Cu	350
T29	12	48	40											800 830	830	AG 207 Ag 212	Die cut Double brazing, Fe/Fe Fe/Cu	412
T68	20	45	35											690 810	810	AG 206 -	Die cut Double brazing, Fe/Fe Fe/Cu	380/430
T77	25	40	35											700 790	780	AG 205 Ag 225	Low Ag contain high temperature narrow melting range	380/430
T77S	25	40	33			2								680 760	760	AG 108 Ag 125	Medium Ag contain good fluidity	360/480
T79	30	38	32											680 765	750	AG 204 Ag 230	Medium Ag contain good fluidity	380/430
T79S	30	36	32			2								665 755	740	AG 107 Ag 130	Medium Ag contain good fluidity. Refrigerators, brass brazing	360/480
T80S	34	36	27			3								630 730	710	AG 106 Ag 134	Medium Ag contain good fluidity	360/480
T90S	40	30	28			2								650 710	690	AG 105 Ag 140	Medium Ag contain excellent fluidity	350/430
T97	44	30	26											675 735	730	AG 203 Ag 244	Ductile and tenacious bond, medium temperature	400/480
T96S	45	27	25			3								640 680	670	AG 104 Ag 145	Medium Ag contain excellent fluidity	350/430
T99S	55	21	22			2								630 660	650	AG 103 Ag 155	Low temperature excellent fluidity	350/430
T99	56	22	17			5								620 651	655	AG 102 Ag 156	Low temperature excellent fluidity	350/430
T600	60	26	14											695 730	750	AG 202 -	High Ag contain goldsmith industry	
T700	67	22	11											700 730	750	-	High Ag contain goldsmith industry	
T720	72	28												780	780	AG 401 Ag 272	High Ag contain goldsmith industry	380/390
T750	74	18	8											740 780	780		High Ag contain goldsmith industry	
T500	49	16	23				4,5				7,5			625 705	705	AG 502 Ag 449	Furnace brazing eutectic	380/470
T530 Trimetallico Z	49	27	21				0,5				2,5			680 705	690	-	Hard metal tools	300
T520N	50	20	28				2							660 705	750	-	Hard metal tools	
T992	56	42					2							770 895	900	- Ag 456	Brazing Furnace	

Copper phos alloys

CODE	CHEMICAL COMPOSITION													MELTING RANGE	BRAZING TEMPERATURE	EN 1044 ISO 17672	TYPICAL APPLICATIONS	TENSILE STRENGTH (N/MM²)
	Ag	Cu	Zn	P	Si	Sn	Ni	Cr	B	Al	Mn	Mg	Fe					
FH51	-	94		6										710 - 890	760	CP 203 CuP 179	Copper/copper brazing for air condition heat exchange and copper pipe	250
FH52	-	93,2		6,8										710 - 820	730	CP 203 CuP 180		250
FH49	-	93		7										710 - 793	730	CP 202 CuP 181		250
FH50	-	92		8										710 - 770	730	CP 201 CuP 182		250
FH55	-	86		7		7								650 - 700	700	CP 302 CuP 386		250
FH47	0,4	93		6,6										710 - 820	730	-		250
FH48	2	91,5		6,5										645 - 825	740	CP 105 CuP 279		250
FH45	5	89		6										645 - 815	710	CP 104 CuP 281		250
FH46	6	87		7										645 - 725	710	-		250
FH35	15	80		5										645 - 800	700	CP 102 CuP 284	Electrical contacts for air condition heat exchange	250
FH32	18	75		7										645	650	CP 101 CuP 286	Electrical contacts for air condition heat exchange	250

Copper and copper alloys

CODE	CHEMICAL COMPOSITION													MELTING RANGE	BRAZING TEMPERATURE	EN 1044 ISO 17672	TYPICAL APPLICATIONS	TENSILE STRENGTH (N/MM²)
	Ag	Cu	Zn	P	Si	Sn	Ni	Cr	B	Al	Mn	Mg	Co					
Rame		99,0												1083	1100	CU 103 Cu 99	Carbon steel stainless steel in reducing atmosphere	356/371
9010		90				10								955 1000	1050		Carbon steel stainless steel in reducing atmosphere lower temperature compare to Cu	238/276
9406		94				6								950 1065	1070	CU 201 Cu 922		326/417
9604		96				4								960 1060	1060			326/417
6980		98					2							1085 1100	1100		Carbon steel stainless steel in reducing atmosphere increase the joint strength	301/408
6970		97					3							1085 1100	1100			301/408
6971		97					2,5		0,05					1085 1100	1100	CU 105	Carbon steel stainless steel and hard metals in reducing atmosphere. Increase the joint strength and the wettability	301/408
68610		86									10		4	960 1030	1120			
68710		87					2,5				10			960 1030	1120			
66020		60					3				20			960 1030	1120			

Aluminum alloys

CODE	CHEMICAL COMPOSITION													MELTING RANGE	BRAZING TEMPERATURE	EN 1044 ISO 17672	TYPICAL APPLICATIONS	TENSILE STRENGTH (N/MM²)
	Ag	Cu	Zn	P	Si	Sn	Ni	Cr	B	Al	Mn	Mg	Fe					
ALL95					5					95				566 - 630		AL101 Al105	Al/Al brazing	170/210
ALL87					12					88				575 - 585	630	AL104 Al112		100
ALL MG5					0,3					94,7		5		566 - 650		-	Al/Mg brazing	
ALL99					0,5					99,5				660		-	Aluminum Tig welding	
ALL84S			72							22				397 - 483	490	-	Al/Al Al/Cu brazing	
ALL86S					10					90				575 - 585	600	AL103 Al110		170/210

Ni Cr alloys

CODE	CHEMICAL COMPOSITION													MELTING RANGE	BRAZING TEMPERATURE	EN 1044 ISO 17672	TYPICAL APPLICATIONS	TENSILE STRENGTH (N/MM²)
	Ag	Cu	Co	P	Si	C	Ni	Cr	B	W	Mn	Mg	Fe					
9760				10	4,5		76	14						890	1080	NI 107 Ni 710	Honeycomb, thin walled tubes, nuclear applications	
9824					4,5		82	7	3				3	970 - 1000	1080	NI 102 Ni 620	Jet engines, EGR, stainless steel pipes, tools	255/383
9708					10		71	19						1080 - 1135	1150 - 1204	NI 105 Ni 650	High corrosion resistance	676
9890				11			89							875	927 - 1093	NI 106 Ni 700	Honeycomb, thin walled tubes, nuclear applications	
9930					4,5		93		3					980 - 1040	1040	NI 103 Ni 630	Honeycomb, thin walled tubes, Jet engines, stainless steel pipes	234/393
9925					3,5		92		2				max 1.5	980 - 1070	1040	NI 104 Ni 631	Honeycomb, thin walled tubes, Jet engines, stainless steel pipes	
9815							81,5	15,5	3,25				max 1.5	1055	1080	NI109 Ni 612	Eutectic for diffusion brazing	
9610				6	4		61	29						1100	1070 - 1090	-	EGR	
9690		9		9	0,1		69	12						870 - 890	1050	-	Honeycomb, thin walled tubes, resistance	
9655		4,5			7		65				22,5			980 - 1010	1100	NI 108 Ni 800	Hhoneycomb, thin walled tubes	
9733					4,5	0,8	73	14	3,5				4,5	980 - 1060	1100	NI 600 -	Et engines	334/383
9740					4,5		74	14	3,5				4,5	980 - 1070	1100	NI 1A1 Ni 610	Et engines	334/383
9170			51		8	0,4	17	19	0,8	4				1120 - 1150	1150 - 1230	CO 101 Co 900	Co based alloys	

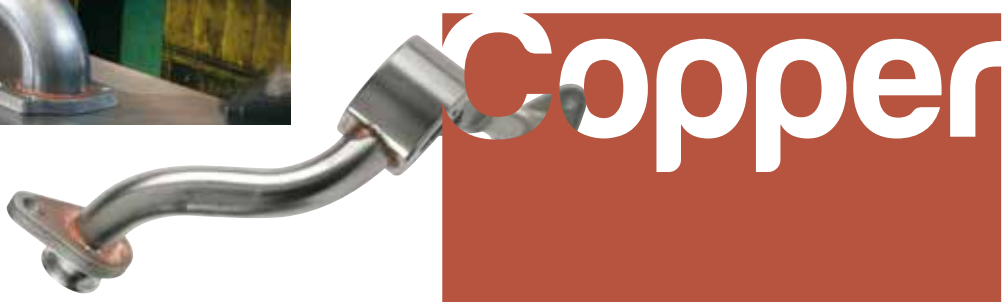
Brass

CODICE	CHEMICAL COMPOSITION													MELTING RANGE	BRAZING TEMPERATURE	EN 1044 ISO 17672	TYPICAL APPLICATIONS	TENSILE STRENGTH (N/MM²)
	Ag	Cu	Zn	P	Si	Sn	Ni	Cr	B	Al	Mn	Mg	Fe					
S21		59	40		0,25									875 895	900	CU 301 Cu 470a	Carbon steel stainless steel	350
SM23		59	40		0,15	1					0,8			880 900	900	-	Carbon steel stainless steel excellent with liquid flux	380/420
ST22		59	40		0,25	1								800 840	870	-	Carbon steel stainless steel with a good fluidity excellent with liquid flux	380/420
SN32		57	38		0,15		5							860 910	930	-	Carbon steel stainless steel increase the tensile strength of the join	650
SN34		51	38		0,2		10							900 930	930	-	Carbon steel stainless steel increase the tensile strength of the join	700
SN36		50	38		0,15		9							890 920	910	CU 305 Cu 773	Carbon steel stainless steel increase the tensile strength of the join	690
SN37A	1	48	42		0,15		9,5							870 900	890	-	Carbon steel stainless steel increase the tensile strength of the join	735

Copper paste

CODE	CHEMICAL COMPOSITION %						EN 1044 ISO 17672	MELTING RANGE	APPLICATIONS
	Cu	Sn	Ni	Cu2O	Others	Total impurity max			
CUM110WS	99,0	-	-	- (10%)	-	0,30 Escl. O	CU 103 Cu 099	1083	Top level Copper brazing Paste, used to join ferrous metals. Ni base alloys and Cu-Ni alloys, for continuous belt furnace with any protective atmosphere
CUM1WS	99,0	-	-	-	-	0,30 Escl. O	CU 101 Cu 110	1083	Copper brazing paste Cu2O free, used to join ferrous metals. Ni base alloys and Cu-Ni alloys, for continuous belt furnace with any protective atmosphere
CUM220WS	99,0	-	-	(20%)	-	0,30 Escl. O	CU 103 Cu 099	1083	Medium level copper brazing paste, used to join ferrous metals. Ni base alloys and Cu-Ni alloys, for continuous belt furnace with any protective atmosphere, should be a valid cheap alternative to CUM110WS
CUM1	99,9	-	-	-	-	0,30 Escl. O	CU 101 Cu 110	1083	Copper brazing paste Cu2O free, oil based binder, used to join ferrous metals. Ni base alloys and Cu-Ni alloys, for continuous belt furnace with any protective atmosphere, particularly suitable for vacuum furnace
CUM1WSS	99,9	-	-	-	-	0,30 Escl. O	CU 101 Cu 110	1083	Copper brazing slow dry paste Cu2O free, used to join ferrous metals. Ni base alloys and Cu-Ni alloys, for continuous belt furnace with any protective atmosphere
CUM110WSS	99,0	-	-	(10%)	-	0,30 Escl. O	CU 103 Cu 099	1083	Top level Copper brazing slow dry paste, used to join ferrous metals. Ni base alloys and Cu-Ni alloys, for continuous belt furnace with any protective atmosphere

Higher copper purity levels on request.



Copper

CuPROM

CuPROM

Copper

Copper paste

CODE	CHEMICAL COMPOSITION %						EN 1044 ISO 17672	MELTING RANGE	APPLICATIONS
	Cu	Sn	Ni	Cu2O	Others	Total impurity max			
6971	97	-	3	-	B 0,02-0,05	0,30 Escl. O	CU 105	1085 - 1100	Cu Ni brazing paste, used to join ferrous metals, Ni base alloys and Cu-Ni alloys, for continuous belt furnace with any protective atmosphere, it is especially required to increase the mechanical resistance of the joint and increase the wettability
6970	97	-	3	-		0,30 Escl. O	-	1085 - 1100	Cu Ni brazing paste, used to join ferrous metals, Ni base alloys and Cu-Ni alloys, for continuous belt furnace with any protective atmosphere, it is especially required to increase the mechanical resistance of the joint
6980	98	-	2	-		0,30 Escl. O	-	1085 - 1100	
68610	86	-	-	-	Mn 10 Co 4	0,30 Escl. O	-	980 - 1030	Cu-Mn alloy for special puorpose, for continuous belt furnace with any protective atmosphere, it is especially required to increase the mechanical resistance of the joint
68710	87	-	2,5	-	Mn 10 Co 4	0,30 Escl. O	-	965 - 995	
66020	60	-	20	-	Mn 20	0,30 Escl. O	-	900 - 1040	
9010	90,0	10,0	-	-	-	0,30 Escl. O	-	955 - 1000	Cu-Sn based alloys, used for ferrous alloys, Ni based alloys and Cu-Ni based alloys
9406	94	6	-	-	-	0,30 Escl. O	-	950 - 1065	
9604	96	4	-	-	-	0,30 Escl. O	-	950 - 1065	

Nickel Chrome

Paste NI Cr

CODE	CHEMICAL COMPOSITION %									EN 1044 ISO 17672	MELTING RANGE	BRAZING TEMPERATURE RANGE	APPLICATIONS
	Ni	Cr	B	P	Si	Fe	C	Cu	Others				
9760	76	14	-	10	4,5	-	Max 0,06	-	-	NI 107 Ni 710	890	1080	Low-melting, free-flowing filler metal for honeycomb structures and thin-walled tube assemblies
9824	82	7	3	-	4,5	3	Max 0,06	-	-	NI 102 Ni 620	970 - 1000	1080	High melting filler metal high mechanical, oxidation and corrosion resistance
9708	71	19	-	-	10	-	Max 0,06	-	-	NI 105 Ni 650	1080 - 1135	1150 - 1204	Boron Free Ni alloy with high silicon content, good choice for narrow deep joints, the high Cr content will endure corrosive or oxidation service conditions
9890	89	-	-	11	-	-	Max 0,06	-	-	NI 106 Ni 700	875	927 - 1093	Free-flowing, low melting, chromium-free filler metal. Minimized base metal erosion
9930	93	-	3	-	4,5	-	max 0,06	-	-	NI 103 Ni 630	980 - 1040	1040	Cr free filler metal used for honey-comb assemblies, jet engines stainless-steel; excellent choice for deep narrow joints
9925	92	-	2	-	3,5	max 1.5	max 0,06	-	-	NI 104 Ni 631	980 - 1070	1040	Similar to 9930 but with a wider melting range
9815	81,5	15,5	3,25	-	-	max 1.5	max 0,06	-	-	NI 109 Ni 612	1055	1080	Ni Cr B filler metal, particularly well suited for diffusion brazing applications and further process
9610	61	29	-	6	4	-	max 0,06	-	-	-	1070 - 1090	1100	A unique chemical composition to achieve what the traditional Ni brazing alloy cannot : excellent wetting proprieties, excellent corrosion resistance and very goods joint strength
9690	69	12	-	9	0,1	-	max 0,06	9	-	-	870 - 890	1050	A modify version of 9760 (NI107) with very good wetting proprieties, excellent corrosion resistance and very good joint strength
9655	65	-	-	-	7	-	max 0,06	4,5	Mn 22,5	NI 108 Ni 800	980 - 1010	1100	Ni Cu Mn alloy for stainless steel and honeycomb structure. To be used in very pure atmosphere
9733	73	14	3,5	-	4,5	4,5	0,7	-	-	Ni 600	980 - 1060	1100	Alloy for strong and high temperature design joint as jet
9740	74	14	3,5	-	4,5	4,5	max 0,06	-	-	NI 1A1 Ni 610	980 - 1070	1100	A modified version of the 9733 with low C contain for strong and high temperature design joint as jet
9170	17	19	0,8	max 0,02	8	max 0,1	0,4	-	W 4 Co 51	CO 101 Co 900	1120 - 1230	1150 - 1230	High temperature alloy with low penetration capability for Co based alloy

Other Pastes

Silver pastes

TWINFLUX

CODE	COMPOSITION %				MELTING RANGE	EN 1044 ISO 17672	APPLICATIONS
	Ag	Cu	Zn	Others			
T68	20	45	35		690 - 810	AG 206 -	Tough and durable alloy, low Silver content
T80S	34	36	27	Sn3	630 - 730	AG 106 Ag 134	General purpose alloys, medium Silver content
T90S	40	30	28	Sn2	650 - 710	AG 105 Ag 140	
T96S	45	27	25	Sn3	640 - 680	AG 104 Ag 145	High Silver content alloys, narrow melting range, excellent capillarity and fluidity. Ideal for brazing thin joints
T99S	55	21	22	Sn2	630 - 660	AG 103 Ag 155	
T99	56	22	17	Sn5	620 - 655	AG 102 Ag 156	
T720	72	28	-	-	780	AG 401 Ag 272	Eutectic alloy, suitable for brazing in furnace or vacuum furnace
T992	56	42		Ni 2	770 - 895	- Ag 456	Zn free alloy for vacuum or belt furnace brazing process
T500	49	16	23	Ni 4,5 Mn 7,5	625 - 705	AG 502 Ag 449	Silver based alloys for tools and hard metals
T520N	50	20	28	Ni 2	660 - 705	- Ag 450	
T530	49	27	21	Ni 0,5 Mn 2,5	680 - 705	-	

Silver pastes

SOFTFLUX

CODE	COMPOSITION %				MELTING RANGE	EN 1044 ISO 17672	APPLICATIONS
	Ag	Cu	P	Sn			
FH52	-	93,2	6,8	-	714 - 820	CP 203 CuP 180	Copper Phosphorus alloys, Copper Phosphorus Tin alloys, Copper Phosphorus Silver based alloys. Suitable for brazing copper-copper, copper-brass, with the flux, mostly used in conditioning and hydraulic fields
FH49	-	93	7	-	710 - 820	CP 202 CuP 181	
FH55	-	86	7	7	650 - 700	CP 302 CuP 386	
FH46	6	87	7	-	645 - 725	-	
FH35	15	80	5	-	650 - 800	CP 102 CuP 284	
FH32	18	75	7	-	645	CP 101 CuP 286	

Phos Copper pastes

CODE	CHEMICAL COMPOSITION %				EN 1044 ISO 17672	MELTING RANGE	APPLICATIONS
	Al	Si	Zn	Mg			
A85M20WS	15		85	-	- -	382 - 455	Used to connect aluminum tubes and aluminum alloys for heat exchangers, air conditioning and capacitors. This Paste contains flux at low temperature
A87M11WS	88	12	-	-	AL 104 Al 112	575 - 585	Used to connect aluminum tubes and aluminum alloys for heat exchangers, air conditioning and capacitors
A87M14020WS	88	12	-	-	AL 104 Al 112	575 - 585	Used to connect aluminum tubes and aluminum alloys for heat exchangers, air conditioning and capacitors. This Paste contains a special flux that while being active, releases neutral or slightly corrosive residues
A87M14016	88	12	-	-	AL 104 Al 112	575 - 585	Used to connect aluminum tubes and aluminum alloys for heat exchangers, air conditioning and capacitors. This Paste contains flux in oily support

Solder pastes

ALLOMIX

CODE	COMPOSITION %			MELTING RANGE	APPLICATIONS
	Sn	Pb	Others		
ST60	60	40	-	183 - 188	Tin-lead based alloy
ST100	100		-	242	Pure tin
ST130	96,5	-	Ag 3,5	221	Tin Silver based alloy
ST150	95	-	Ag 5	225 - 245	
ST124	99	-	Cu 1	230 - 240	Tin copper based alloy, used as Pb alternative
ST125	97	-	Cu 3	230 - 250	

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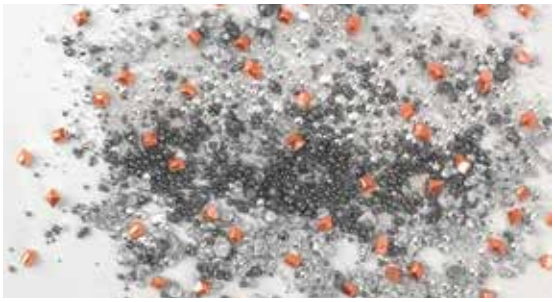
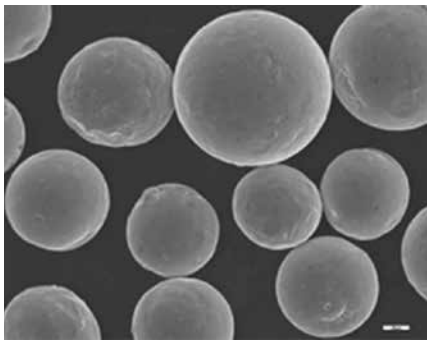
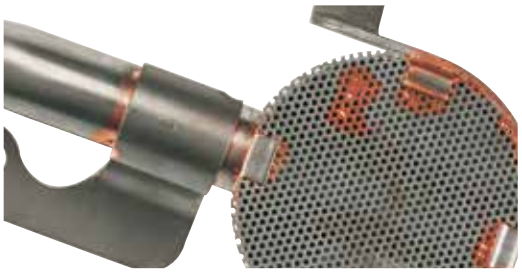
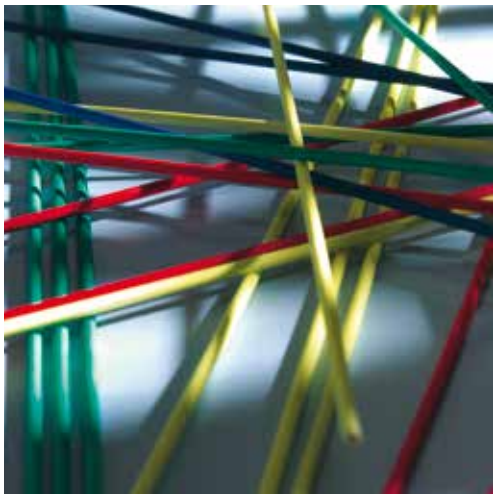
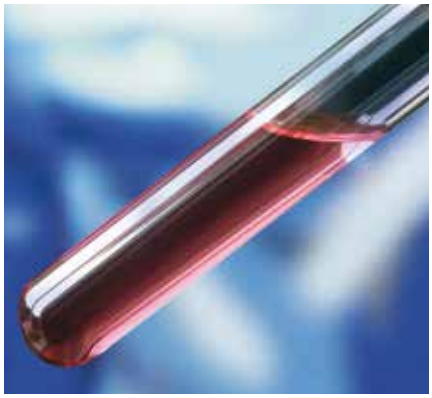


Atomized metal powders







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