

TECHNICAL DATA SHEET 500

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672	NFC 90550	DIN 1707	EN 29453
Sn60Pb40	190	-	B.Sn60Pb	L-Sn 60Pb	S-Sn 60 Pb 40 E

Characteristics:

BRAZETAIN F-Pb 40 is basically a binary alloy of Tin / Lead near the Eutectic composition.

Flux included type CR (Class 2 : 1.6 top 2.6 %) / Cl < 1% Acidity ind : 200 (ECI > 0.7%)

Typical Chemical Compositions (%):

Sn	Pb	Ag	Cd	Sb	Fe	Zn/Al/As	other	Max. impurities
60	40	<0.005	<0.002	<0.005	<0.02	<0.001	<0.05	<0.20

Typical Physical Properties:

Coating Colour	Solidus (°C)	Liquidus (°C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Metal	183	190	8.65	-	-	-	-

Temperatures of Uses : Iron : 330 à 380 °C

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

IS recommended to clean the Residue after Brazing/Soldering

Standard Size , Types & Heat Source Recommendations:

Size (mm)	Type			
	Bare	Coated	Coil	Preforms
Spool 0.5 to 5 mm	x	x	√	x

Customised size other than above standard dimensions is solicited case to case basis

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.