

REFRIGERATION & AIR-CONDITIONING

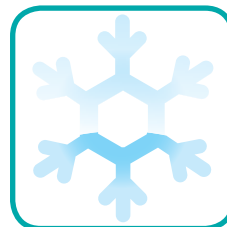
BRAZING TECHNOLOGY

Service Tools for Installation & Servicing



Delivery programme dedicated to:

- Distributors of refrigeration & A/C equipment
- Installers
- Service companies



STELLA
WELDING ALLOYS

HEATING, COOLING AND AIR CONDITIONING - INSTALLATION AND SERVICING

A selection of brazing alloys to meet the needs of professionals for joining metals in installation, maintenance, repair, servicing and plumbing work.

Application areas:

Refrigeration, Air Conditioning & Heating, units and plants

Water, gas and steam distribution piping

Floor heating piping, manifolds, etc.

COPPER-PHOSPHOROUS ALLOYS - WITH AND WITHOUT SILVER

These alloys represent the cheapest and easiest solution for fast and reliable joining of copper and copper alloys.

CODE	COMPOSITION %				MELTING RANGE SOL - LIQ	FLOW POINT	STANDARD	NOTES
	Ag	Cu	P	Sn	°C	°C	ISO 17672	

ALLOYS - BARE RODS

CODE	Ag	Cu	P	Sn	MELTING RANGE SOL - LIQ °C	FLOW POINT °C	STANDARD	NOTES
CuP6		94	6		710-890	760	CuP 179	RoHS Compliant alloys. For copper-copper and copper-brass joints. For joining copper to copper no flux is necessary. These alloys are not suitable for joining ferrous materials, steels and nickel alloys. They are also not suitable to be used in sulfur containing atmospheres. Alloys with Silver are recommended for joints subject to vibrations. These alloys are available as rods, flux-coated rods, wires and rings.
CuP7		93	7		710-820	730	CuP 180	
CuP8		92	8		710-770	720	CuP 182	
CuP7Sn		86	7	7	650-700	700	CuP 386	
Ag2CuP	2	91,5	6,5		645-825	740	CuP 279	
Ag5CuP	5	89	6		645-815	710	CuP 281	
Ag15CuP	15	80	5		645-800	700	CuP 284	

FLUXES - POWDER AND PASTE

FLUX AG4	General purpose. For copper-brass joints.
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ALUMINIUM AND ZINC-ALUMINIUM ALLOYS

Low temperature brazing of aluminium.

CODE	COMPOSITION %			MELTING RANGE SOL - LIQ	NOTES
	Al	Si	Zn	°C	

ALLOYS

AlSi12	88	12		575-585	Brazing of aluminium.
AlZn78	22		78	441-471	For copper-aluminium and brass-aluminium joints.
AlZn98	2		98	430-440	Also available as flux-cored rods and wires (non-corrosive flux).

FLUXES

FLUX AL1/d	Corrosive flux for flame brazing with AlSi12.
FLUX AL6	Non corrosive flux for brazing with Zinc-Aluminium alloys.

CADMIUM-FREE BRAZING ALLOYS WITH HIGH SILVER CONTENT

RoHS compliant alloys, for high and very high quality joining of different kinds of materials, such as: steel, stainless steel, copper and copper alloys, nickel alloys, etc. with the exception of aluminium and magnesium.

CODE	COMPOSITION %					MELTING RANGE SOL - LIQ	STANDARD	NOTES
	Ag	Cu	Zn	Sn	Other	°C	ISO 17672	

ALLOYS

Ag12	12	48	40		Si 0,15	800-830	Ag 212	All the alloys in this table are cadmium-free and RoHS Compliant. They are suitable to join a wide range of ferrous and non ferrous metals (copper, brass, bronze, steel, stainless steel, nickel alloys, etc.), with the exception of aluminium and magnesium. Available as rods, flux coated rods, wires and rings (dimensions according to customer's need).
Ag20	20	44	36		Si 0,15	690-810		
Ag25Sn	25	40	33	2		680-760	Ag 125	
Ag30Sn	30	36	32	2		665-755	Ag 130	
Ag34Sn	34	36	27,5	2,5		630-730	Ag 134	
Ag35	35	32	33			685-755	Ag 235	
Ag40Sn	40	30	28	2		650-710	Ag 140	
Ag45Sn	45	27	25,5	2,5		640-680	Ag 145	
Ag55Sn	55	21	22	2		630-660	Ag 155	
Ag56Sn	56	22	17	5		620-655	Ag 156	
Ag60Sn/1	60	30		10		600-730	Ag 160	Suitable for stainless steel in wet conditions / moisture rich environments.
Ag72Zn	72		28			710-730		Alloys without copper, ammonia resistant. Ag85Mn is also suitable for stainless steel in wet conditions / moisture rich environments.
Ag85Mn	85				Mn 15	960-970	Ag 485	

FLUXES

FLUX AG1	General purpose.
FLUX AG4	General purpose. Wider range of working temperatures.
FLUX AG7	General purpose. Also for stainless steel.



SOFT SOLDERS

Joining of various materials: steel, stainless steel, copper and its alloys, aluminium, etc.

CODE	COMPOSITION %			MELTING RANGE SOL - LIQ	STANDARD	NOTES
	Sn	Cu	Ag	°C	EN 29453	

ALLOYS

SnCu97/3	97	3		230-250	S-Sn97Cu3	Lead-free, RoHS compliant alloys. Suitable for potable water and alimentary products.
Ag3,5Sn	96,5		3,5	221	S-Sn97Ag3	
Ag5Sn	95		5	221-235		

FLUXES

FLUX SN1	General purpose. For ferrous and non ferrous metals. Available in liquid and in paste.
FLUX SN35	For aluminium and low-alloyed aluminium alloys.



Personalized packing and labels

Different solutions for products packaging especially designed for small quantities, and for sale in shops, stores, resellers.

Strong, unbreakable packages that can also be opened and re-closed easily.

Well suited for installers who need to carry brazing material with them.

Pack of materials in quantity of your choosing. Study of personalized labels.



Rods marking

Either on bare and coated rods by printing personalized codes.



Flux packing

Available different type of thermo-sealed jars.

Quality preserved from leakages and air/moisture infiltrations.

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ISO 9001/2008 - Cert. N° 1155

STELLA

WELDING ALLOYS

Reliability and Competence