

FONTARGEN A 644

Copper-bearing, lead-free soft solder alloy



EN ISO 9453:	S-Sn97Cu3 / Alloy-no. 402
DIN EN 29545.1 (Flux)	F 600: 3.1.1.A (corrosive fluid, for low alloyed and alloyed steel and heavy metals) F 600 CW: 3.1.1.C (paste-like, soldering flux, activated, limited corrosive)

Composition, typical analysis (% w/w):

Cu	Sn
3	Remainder

Mechanical and physical properties:

Melting range:	230 - 250 °C
Tensile strength (solder):	44 N/mm ²
On Ms 58:	53 N/mm ²
Shear strength on Cu:	30 N/mm ²
On Ms:	20 N/mm ²
On St:	25 N/mm ²
Hardness (BHN):	15 HB
Electrical conductivity:	8.5 Sm/mm ²
Specific gravity (metal):	7.3 g/cm ³

Characteristics / Applications:

Fittings solder for copper pipe installations and plumbing works. Work on metal goods. Suitable for the use in the foodstuffs industry. In terms of DVGW sheet GW 2 this solder is suited for copper pipe installations. Lead- and cadmium-free soft solder. The copper content ensures that the tin does not alloy with the copper of the soldering rod.

Heat sources:

Acetylene torch (fuel gas excess), air-gas torch, soldering lamp, soldering iron, induction, resistance heating, dip bath.

Availability:

Bare rods	Coated rods	Wire	Foil	Preforms	Powder	Paste
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