



Technical Data Sheet BrazeTec 4076

TD TM-BT 0006 E.00



Inhalt

Standard

DIN EN ISO 17672
(DIN EN 1044)
(AWS 5.8)

Ag 140
(AG 105)
(BAg-28)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]
Max. impurities [wt.-%]

Ag 40; Cu 30; Zn 28; Sn 2
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
0.15

Technical data

Melting range	approx. 650 - 710 °C
Working temperature	approx. 690 °C
Density	approx. 9.1 g/cm ³
Tensile strength acc. DIN EN 12797	with S235: 350 MPa; with E295: 430 MPa
Operating temp. of brazed joint	approx. -200 °C to +200 °C (without loss in strength)

Standard delivery forms *

Wire:	1.0 - 1.5 - 2.0 mm Ø
Rods:	1.0 - 1.5 - 2.0 mm Ø, 500 mm length
Ribbon:	0.1/ 0.2/ 0.3/ 0.4 mm thickness and 70 mm width
Preforms:	rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

*Other delivery forms upon request

Applications

BrazeTec 4076 is a low melting silver based brazing alloy with excellent flow characteristics. It can be used for brazing any steels, copper and copper based alloys as well as for nickel and nickel based alloys.

It can be used for brazing with flame or induction brazing procedures.

Typical applications are found e.g. in automotive and in the electric industry.

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