



Technical Data Sheet BrazeTec CoMet 4404U



TD TM-BT 0408 E.00

Inhalt

Standard

Brazing Alloy:
DIN EN ISO 17672 Ag 244
(DIN EN 1044) (AG 203)
Flux:
US-Standard ANSI/AWS A5.8 FH10

Brazing Alloy

Nominal composition [wt.-%] Ag 44; Cu 30; Zn 26
Permitted impurities max. [wt.-%] Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
Max. impurities [wt.-%] 0.15

Technical data

Melting range approx. 675 - 735 °C
Working temperature approx. 730 °C
Density approx. 9.1 g/cm³
Tensile strength acc. DIN EN 12797 with S235: 400 MPa; with E295: 480 MPa
Elongation approx. 25 %
Electrical Conductivity approx. 11.2 m/Ωmm²
Operating temp. of brazed joint approx. -200 °C to +200 °C (without loss in strength)

Standard delivery forms*

Rods: 1.5 - 2.0 mm Ø, 500 mm length

*Other delivery forms upon request

Applications

BrazeTec CoMet 4404U 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 flame or induction brazing procedures. BrazeTec CoMet 4404U meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German association of Gas and Water).

Typical applications are found e.g. in the plumbing trade, in the refrigeration and air conditioning industry, automotive and in the electric industry.

Note for user: The flux residues are corrosive and have to be removed

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