



Technical Data Sheet BrazeTec CoMet 4576U



TD TM-BT 0403 E.00

Inhalt

Standard

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| Brazing Alloy: | |
| DIN EN ISO 17672 (DIN EN 1044) | Ag 145 (AG 104) |
| Flux: | |
| US-Standard ANSI/AWS A5.8 | FH10 |

Brazing Alloy

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| Nominal composition [wt.-%] | Ag 45; Cu 27; Zn 25,5; Sn 2,5 |
| 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

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| Melting range | approx. 640 - 680 °C |
| Working temperature | approx. 670 °C |
| Density | approx. 9.2 g/cm ³ |
| Tensile strength acc. DIN EN 12797 | with S235: 350 MPa; with E295: 430 MPa |
| Elongation | approx. 10 % |
| Electrical Conductivity | approx. 13.0 m/ Wmm ² |
| Operating temp. of brazed joint | approx. -200 °C to +200 °C (without loss in strength) |

Standard delivery forms*

Rods: 15 - 20 mm Ø, 500 mm length

*Other delivery forms upon request

Applications

BrazeTec CoMet 4576U 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 4576U 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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