Technical Data Sheet BrazeTec 2009

Standard
ISO 17672  Ag 220
(DIN EN 1044)  (AG 206)

Nominal composition [wt.-%]  Ag 20; Cu 44; Zn 36; Si 0.15
Permitted impurities max. [wt.-%]  Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025
Max. impurities [wt.-%]  0.15

Technical data
Melting range acc. ISO 17672  approx. 690 - 810°C
Melting range acc. Measurement  approx. 730 – 810°C (DSC – measurement)
Brazing temperature  approx. 810°C
Density  approx. 8.6 g/cm³
Tensile strength acc. DIN EN 12797  with S235: 380 MPa; with E295: 430 MPa
Shear strength acc. DIN EN 12797  with S235: min 150 MPa
Elongation  approx. 25 %
Electrical Conductivity  approx. 10.6 m/Ωmm²
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 2009 is a 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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