Standard
BrazeTec Standard
(ISO 3677)  (B-Ag49CuZnMnNi 670/690)

Nominal composition [wt.-%]  Ag 49; Cu 27.5; Zn 20.5; Mn 2.5; Ni 0.5
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.-%]  0.3

Technical data
Melting range  approx. 670 - 690 °C
Working temperature  approx. 690 °C
Density  approx. 8.9 g/cm³
Shear strength acc. DIN EN 12797  250 - 300 MPa (carbide/steel)
Electrical Conductivity  approx. 4.0 m/ Ωmm²
Operating temp. of brazed joint  max. 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 4900 A is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. The reachable strength of the joint depends from the parent metals.
It can be used for brazing with flame or induction brazing procedures. Typical applications are found e.g. in the tool industry.

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