Technical Data Sheet BrazeTec 6009

Standard
ISO 17672  
(DIN EN 1044)  
(AWS 5.8)  
Ag 160  
(AG 402)  
(BAg-18)

Nominal composition [wt.-%]  
Ag 60; Cu 30; Sn 10

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. 600 - 730 °C

Working temperature  
approx. 720 °C

Density  
approx. 9.8 g/cm³

Tensile strength acc. DIN EN 12797  
with S235: 390 MPa; with E295: 460 MPa

Elongation  
approx. 35 %

Electrical Conductivity  
approx. 8.7 m/Ω mm²

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 6009 can be used for brazing unalloyed, low and high alloyed, 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. It is well suitable for brazing under protective atmosphere or under vacuum. The brazing temperature in the furnace is determined by the parent metals. Brazing procedures under vacuum should be done at temperatures not much above 900 °C to avoid evaporation of silver as far as possible.

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

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