Technical Data Sheet BrazeTec CoMet 4076U

Standard
Brazing Alloy:
ISO 17672 (DIN EN 1044) (AG 105)
Flux:
US-Standard ANSI/AWS A5.8

Brazing Alloy
Nominal composition [wt.-%] Ag 40; Cu 30; Zn 28; Sn 2
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 acc. ISO 17672 650 - 710 °C
Melting range acc. Measurement approx. 665 - 725 °C (DSC-measurement)
Brazing temperature min. 720 °C
Density approx. 9.0 g/cm³
Tensile strength acc. DIN EN 12797 with S235: 350 MPa; with E295: 430 MPa
Electrical Conductivity approx. 11 m/Ωmm²
Shelf life (flux) min. 6 months, but only at storage temperatures between +5 to +30 °C.
Avoid rapid changes in temperature

Standard delivery forms*
Rods: 1,5 - 2,0 mm Ø, 500 mm length

Applications
BrazeTec CoMet 4076U is a flux coated low melting silver based brazing alloy with excellent flow characteristics. The flux residues are corrosive have to be removed. 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.

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

According to the experience, the fluxing activity of fluxes is also given above the date of expiry (in the original sealed packing). Please consider, that e.g. the loss or the absorption of humidity may influence the adherence of the flux coating

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

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