Technical Data Sheet BrazeTec D 4900.1

Standard
ISO 17672
(DIN EN 1044 )
DIN EN 1045
Ag 449 (Brazing Alloy)
(DIN EN 502)
FH 10 (Flux)

Nominal composition [wt.-%]
Ag 49; Cu 16; Zn 23; Mn 7.5; Ni 4.5
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.-%]
0.30

Technical data
Melting range of brazing alloy approx. 680 - 705 °C
Working temperature approx. 690 °C
Density of brazing alloy approx. 8.9 g/cm³
Density of brazing paste approx. 2.7 g/cm³ (20 °C)
Metal content approx. 65 wt.-%
Grain size of brazing alloy powder < 106 µm
Viscosity 1100 - 1300 dPa s (Haake Viscotester 02; Sp. 2, 20 ±2 °C)
Residues corrosive, soluble in water
Shear strength acc. DIN EN 12797 250 - 300 MPa
Operating temperature of joint max. 200 °C (without loss of strength)
Cleaning agent BrazeTec Cleaning Agent P
Shelf life Can / bucket: min. 6 months
Cartridge: min. 3 months
in the original closed container.
Storage temperature +5 to +30 °C.
Stir cans and buckets well before use.

Packaging
Standard 0.075; 1; 3; 5; 10 kg

Applications
BrazeTec D 4900.1 is a dosable brazing paste for use with brazing machines. It contains flux and a low melting free flowing silver brazing alloy.
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 dosable brazing paste BrazeTec D 4900.1 is suitable for all common brazing methods, like torch brazing, furnace brazing and induction brazing.
Typical applications are found e.g. in the tool industry.

Further comments: Paste residues are corrosive and have therefore to be removed carefully.