

Technical Data Sheet BrazeTec 3476

Standard

ISO 17672
(DIN EN 1044)

Ag 134
(AG 106)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]
0.05

Ag 34; Cu 36; Zn 27.5; Sn 2.5
Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si

Max. impurities [wt.-%]
0.15

Technical data

Melting range acc. ISO 17672
approx. 630 - 730°C

Melting range acc. Measurement
approx. 665 – 745°C (DSC –measurement)

Brazing temperature
approx. 745°C

Density
approx. 8.9 g/cm³

Tensile strength acc. DIN EN 12797
with S235: 360 MPa; with E295: 480 MPa

Shear strength acc. DIN EN 12797
with S235: min 150 MPa

Elongation
approx. 11 %

Electrical Conductivity
approx. 9.28 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 3476 is a low melting 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 flame or induction brazing procedures.

Typical applications are found e.g. in the plumbing trade, in the refrigeration and air conditioning industry, automotive and in the electric industry.

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