

Technical Data Sheet BrazeTec CoMet 3476U

Standard

Brazing Alloy:

ISO 17672
(DIN EN 1044)

Ag 134
(AG 106)

Flux:

US-Standard ANSI/AWS A5.8

FH10

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

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 0.05

0.15

Technical data

Melting range acc. ISO 17672

approx. 630 - 730°C

Melting range acc. Measurement

approx. 655 - 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 at rupture

approx. 11 %

Electrical Conductivity

approx 14,0 m/Ωmm²

Operating temp. of brazed joint

approx. -200°C to +200°C (without loss in strength)

Shelf life (Flux)

6 months in the original closed container storage temperature
+5 to +30°C.

Avoid rapid changes in temperature.

Standard delivery forms*

Rods:

1.0 - 1.5 - 2.0 mm Ø, 500 mm length

*Other delivery forms upon request

Applications

BrazeTec CoMet 3476U 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 brazing with 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.

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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