

**TD-STM-BT-E-0654-00**

## Technical Data Sheet BrazeTec CoMet 4576U

### Standard

Brazing Alloy:

ISO 17672  
(DIN EN 1044)  
(AWS 5.8)

Ag 145  
(AG 104)  
(BAg-36)

Flux:

US-Standard ANSI/AWS A5.8

FH10

### Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]  
impurities [wt.-%]

Ag 45; Cu 27; Zn 25.5; Sn 2.5  
Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05 max.  
0.15

### Technical data

Melting range acc. ISO 17672	approx. 640 - 680°C
Melting range acc. Measurement	approx. 645 - 695°C (DSC-measurement)
Brazing temperature	min. 695°C
Density	approx. 9.1 g/cm <sup>3</sup>
Tensile strength acc. DIN EN 12797	with S235: 350 MPa; with E295: 430 MPa
Shear strength acc. DIN EN 12797	with S235: min 150 MPa
Elongation at rupture	approx. 23 %
Electrical Conductivity	approx. 9.0 m/Ωmm <sup>2</sup>
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 4576U 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.

Details in product brochures or other advertisements about our products, equipment, plant and processes are based on our research and our experience in the field of applied engineering and are merely recommendations. It is not possible to infer any warranted qualities or warranted use from these details, unless they were expressly agreed as a warranted quality. We reserve the right to make technical modifications in the course of our product development.

The user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. This shall also apply to the protection of third party property rights as well as to applications and processes. The properties of samples and specimens are binding only if these have been expressly agreed to define the quality of the goods. Information on the quality and durability and other particulars are warranted only if these are agreed and designated as such. The specifications agreed with the user/purchaser in writing are relevant for the quality of the goods and if specifications have not been agreed in writing, the information contained in our technical data sheets, specifications or drawings.

Any additional or diverging agreements on the quality must be in writing. Any suitability of the product for the presupposed or customary use which supplements or diverges from the agreed quality is out of the question. Our General Conditions of Sale and Delivery shall apply; the current version is available at <http://www.umicore-brasage.fr>.

Druckdatum: 16.08.2018

Seite 1 von 1