

## Technical Data Sheet BrazeTec D 4576.1

### Standard

|               |                        |
|---------------|------------------------|
| ISO 17672     | Ag 145 (Brazing Alloy) |
| (DIN EN 1044) | (AG 104)               |
| (AWS 5.8)     | (Bag-36)               |
| DIN EN 1045   | FH 10 (Flux)           |

### Nominal composition [wt.-%]

|                                   |  |
|-----------------------------------|--|
| Permitted impurities max. [wt.-%] | Ag 45; Cu 27; Zn 25.5; Sn 2.5                                    |
| Max. impurities [wt.-%]           | Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05<br>0.15 |

### Technical data

|                                    |  |
|------------------------------------|--|
| Melting range of brazing alloy     | approx. 640 - 680°C  |
| Melting range acc. Measurement     | approx. 645 - 695°C (DSC-measurement)  |
| Brazing temperature                | approx. 695°C  |
| Density of brazing alloy           | approx 9.1 g/cm <sup>3</sup>   |
| Density of brazing paste           | approx. 2.8 g/cm <sup>3</sup> (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  |
| Tensile strength acc. DIN EN 12797 | with S235: 350 MPa; with S550: 430 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<br>in the original closed container.<br>Storage temperature +5 to +30°C.<br>Stir cans and buckets well before use. |

### Packaging

|          |                       |
|----------|-----------------------|
| Standard | 0.075; 1; 3; 5; 10 kg |
|----------|-----------------------|

### Applications

BrazeTec D 4576.1 is a dosable brazing paste for use with brazing machines. It contains flux and a low melting free flowing silver brazing alloy.

The paste is suitable for brazing copper and copper alloys, nickel and nickel alloys as well as steels. BrazeTec D 4576.1 is suitable for all common brazing methods, like torch brazing, furnace brazing and induction brazing.

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

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

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