TD-STM-BT-E-0409-00

Technical Data Sheet BrazeTec CoMet 3076U

Standard	
Brazing Alloy:	
ISO 17672	Ag 130
(DIN EN 1044)	(AG 107)
Flux:	
US-Standard ANSI/AWS A5.8	FH10
Nominal composition [wt.-%]	Ag 30; Cu 36; Zn 32; Sn 2
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025;
Max. impurities [wt.-%]	Si 0.05 0.15

Technical data	
Melting range acc. ISO 17672	approx. 665 - 755°C
Melting range acc. Measurement	approx. 675 - 760°C (DSC –measurement)
Brazing temperature	min. 760°C
Density	approx 8.8 g/cm³
Tensile strength acc. DIN EN	with S235: 360 MPa; with E295: 480 MPa
12797 Electrical Conductivity	approx 12 m/ Ωmm²
Shelf life (Flux)	min. 6 months, but only at storage temperatures between +5 to +30 °C. Avoid rapid changes in temperature.

Standard delivery forms*	
Rods:	1.5 - 2.0 mm Ø, 500 mm length
*Other delivery forms upon request	

Applications

BrazeTec CoMet 3076U is a flux coated low melting silver based brazing alloy with excellent flow characteristics. The flux residues are corrosive have to be removed. 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.
Typical applications are found e.g. in the electric and automotive 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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