

Technical Data Sheet BrazeTec CoMet 3476U

Standard

Brazing Alloy:

ISO 17672

(DIN EN 1044)

Flux:

US-Standard ANSI/AWS A5.8

Ag 134

(AG 106)

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

Melting range acc. Measurement

Brazing temperature

Density

Tensile strength acc. DIN EN

12797 Shear strength acc. DIN

EN 12797 Elongation at rupture

Electrical Conductivity

Operating temp. of brazed joint

Shelf life (Flux)

approx. 630 - 730°C

approx. 655 - 745°C (DSC –measurement)

approx. 745°C

approx 8.9 g/cm³

with S235: 360 MPa; with E295: 480 MPa

with S235: min 150 MPa

approx. 11 %

approx 14,0 m/ Ωmm²

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

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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