

Technical Data Sheet BrazeTec 4900 A

Standard

BrazeTec Standard
(ISO 3677)

(B-Ag49CuZnMnNi 670/690)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

Ag 49; Cu 27.5; Zn 20.5; Mn 2.5; Ni 0.5

Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05

0.3

Technical data

Melting range

approx. 670 - 690 °C

Working temperature

approx. 690 °C

Density

approx 8.9 g/cm³

Shear strength acc. DIN EN 12797

250 - 300 MPa (carbide/steel)

Electrical Conductivity

approx 4.0 m/Ωmm²

Operating temp. of brazed joint

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

Standard delivery forms*

Wire:

1.0 - 1.5 - 2.0 mm Ø

Rods:

1.0 - 1.5 - 2.0 mm Ø, 500 mm length

Ribbon:

0.1/ 0.2/ 0.3/ 0.4 mm thickness and 70 mm width

Preforms:

rings, shaped parts, sections, stamped and shaped parts,
shims, discs, perforated plates

*Other delivery forms upon request

Applications

BrazeTec 4900 A is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. The reachable strength of the joint depends from the parent metals.

It can be used for brazing with flame or induction brazing procedures.

Typical applications are found e.g. in the tool industry.

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