

## Technical Data Sheet BrazeTec 4900

### Standard

|               |          |
|---------------|----------|
| ISO 17672     | Ag 449   |
| (DIN EN 1044) | (AG 502) |
| (AWS 5.8)     | (BAg-22) |

### Nominal composition [wt.-%]

|                                   |  |
|-----------------------------------|--|
| Permitted impurities max. [wt.-%] | Ag 49; Cu 16; Zn 23; Mn 7.5; Ni 4.5                      |
| Max. impurities [wt.-%]           | 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. 680 - 705 °C                                  |
| Working temperature              | approx. 690 °C  |
| Density                          | approx 8.9 g/cm <sup>3</sup>                          |
| Shear strength acc. DIN EN 12797 | 250 - 300 MPa (carbide/steel)                         |
| Electrical Conductivity          | approx 4.0 m/ □mm <sup>2</sup>                        |
| 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 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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