TD-STM-BT-E-0016-00

Technical Data Sheet BrazeTec 4900

Standard	
ISO 17672	Ag 449
(DIN EN 1044)	(AG 502)
(AWS 5.8)	(BAg-22)
Nominal composition [wt.-%]	Ag 49; Cu 16; Zn 23; Mn 7.5; Ni 4.5
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
Max. impurities [wt.-%]	0.3

Technical data	
Melting range	approx. 680 - 705 °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/ □mm²
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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