TD-STM-BT-E-0406-03

Technical Data Sheet BrazeTec CoMet 2009U

Standard

Brazing Alloy:	
BrazeTec Standard	
(DIN EN 1044)	(AG 206)
(ISO 367)	(B-Cu44ZnAg(Si)-690/810)
Flux:	
US-Standard ANSI/AWS A5.8	FH10

Nominal composition [wt.-%]	Ag 20; Cu 44; Zn 36; Si 0.15
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025
Max. impurities [wt.-%]	0.15

Technical data

Melting range acc. ISO 17672	approx. -°C
Melting range acc. Measurement	approx. 730 - 810°C (DSC –measurement)
Brazing temperature	approx. 810°C
Density	approx 8.6 g/cm³
Tensile strength acc. DIN EN 12797	with S235: 380 MPa; with E295: 430 MPa
Shear strength acc. DIN EN 12797	with S235: min 150 MPa
Elongation	approx. 25 %
Electrical Conductivity	approx 10.6 m/ Ωmm²
Operating temp. of brazed joint	approx. -200°C to +200°C (without loss in strength)
Shelf life (Flux)	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 2009U 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 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.

TVA FR 08 812 96 939
RCS Paris 812 196 939
SIREN 812 196 939

Umicore France
9, rue Réaumur - 75003 Paris
www.umicore-brasage.fr/

Tel.: +33 (1) 85 73 78 96
Fax.: +33 (1) 43 60 52 58
umicore-brasage@eu.umicore.com