TD-STM-BT-E-0407-00

Technical Data Sheet BrazeTec CoMet 2577U

Standard	
BrazeTec Standard (ISO 367)	(*B-Cu37ZnAgMnNi 630/800*)
Flux: US-Standard ANSI/AWS A5.8	FH10
Nominal composition [wt.-%]	Ag 24,5; Cu 37.2; Zn 33.5; Ni 2; Mn 2; Si max. 0.3
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025
Max. impurities [wt.-%]	0.3
Technical data	
Melting range acc. ISO 17672	approx. -°C
Melting range acc. Measurement	approx. 630 - 800°C
working temperature	approx. 770°C
Density	approx 8.47 g/cm³
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:	1.5 mm Ø, 500 mm length
*Other delivery forms upon request	

Applications

BrazeTec CoMet 2577U is a flux coated low melting silver based brazing alloy with excellent flow characteristics. It is an especially developed brazing alloy for avoiding a liquid metal embrittlement during brazing galvanized or naked steel tubes in the refrigeration- and air conditioning industry. But it is also suitable for brazing any other steels, copper and copper based alloys as well as for nickel and nickel based alloys.
It can be used for brazing with flame.

Typical applications are found e.g. in the electric and automotive 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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