

Technical Data Sheet BrazeTec CoMet 4576U

Standard

Brazing Alloy:

ISO 17672
(DIN EN 1044)
(AWS 5.8)

Ag 145
(AG 104)
(BAg-36)

Flux:

US-Standard ANSI/AWS A5.8

FH10

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]
impurities [wt.-%]

Ag 45; Cu 27; Zn 25.5; Sn 2.5
Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05 max.
0.15

Technical data

Melting range acc. ISO 17672	approx. 640 - 680°C
Melting range acc. Measurement	approx. 645 - 695°C (DSC-measurement)
Brazing temperature	min. 695°C
Density	approx. 9.1 g/cm ³
Tensile strength acc. DIN EN 12797	with S235: 350 MPa; with E295: 430 MPa
Shear strength acc. DIN EN 12797	with S235: min 150 MPa
Elongation at rupture	approx. 23 %
Electrical Conductivity	approx. 9.0 m/Ωmm ²
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 4576U 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 plumbing trade, in the refrigeration and air conditioning industry, 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.

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