

Technical Data Sheet BrazeTec 4404

Standard

ISO 17672
(DIN EN 1044)
(AWS 5.8)

Ag 244
(AG 203)
(BAg-5)

Nominal composition [wt.-%]

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

Ag 44; Cu 30; Zn 26
Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05
0.15

Technical data

Melting range acc. ISO 17672	approx. 675 - 735°C
Melting range acc. Measurement	approx. 675 - 735°C (DSC –measurement)
Brazing temperature	approx. 735°C
Density	approx 9.1 g/cm ³
Tensile strength acc. DIN EN 12797	with S235: 400 MPa; with E295: 480 MPa
Shear strength acc. DIN EN 12797	with S235: min 150 MPa
Elongation	approx. 25 %
Electrical Conductivity	approx 10.92 m/ Ωmm ²
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 4404 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 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.

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