

Technical Data Sheet BrazeTec D 4576.1

Standard

ISO 17672	Ag 145 (Brazing Alloy)
(DIN EN 1044)	(AG 104)
(AWS 5.8)	(Bag-36)
DIN EN 1045	FH 10 (Flux)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]	Ag 45; Cu 27; Zn 25.5; Sn 2.5
Max. impurities [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
	0.15

Technical data

Melting range of brazing alloy	approx. 640 - 680°C
Melting range acc. Measurement	approx. 645 - 695°C (DSC-measurement)
Brazing temperature	approx. 695°C
Density of brazing alloy	approx 9.1 g/cm ³
Density of brazing paste	approx. 2.8 g/cm ³ (20°C)
Metal content	approx. 65 wt.-%
Grain size of brazing alloy powder	< 106 µm
Viscosity	1100 - 1300 dPa s (Haake Viscotester 02; Sp. 2; 20 ±2°C)
Residues	corrosive, soluble in water
Tensile strength acc. DIN EN 12797	with S235: 350 MPa; with S550: 430 MPa
Operating temperature of joint	max. 200 °C (without loss of strength)
Cleaning agent	BrazeTec Cleaning Agent P
Shelf life	Can / bucket: min. 6 months
	in the original closed container.
	Storage temperature +5 to +30°C.
	Stir cans and buckets well before use.

Packaging

Standard	0.075; 1; 3; 5; 10 kg
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Applications

BrazeTec D 4576.1 is a dosable brazing paste for use with brazing machines. It contains flux and a low melting free flowing silver brazing alloy.

The paste is suitable for brazing copper and copper alloys, nickel and nickel alloys as well as steels. BrazeTec D 4576.1 is suitable for all common brazing methods, like torch brazing, furnace brazing and induction brazing.

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

Further comments: Paste residues are corrosive and have therefore to be removed carefully.

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