TD-STM-BT-E-1140-00

Technical Data Sheet BrazeTec D 4900.1

Standard	
ISO 17672	Ag 449 (Brazing Alloy)
(DIN EN 1044)	*(AG 502)*
DIN EN 1045	FH 10 (Flux)
Nominal composition [wt.-%]	Ag 49; Cu 16; Zn 23; Mn 7.5; Ni 4.5
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
Max. impurities [wt.-%]	0.30
Technical data	
Melting range of brazing alloy	approx. 680 - 705 °C
Working temperature	approx. 690 °C
Density of brazing alloy	approx. 8.9 g/cm³
Density of brazing paste	approx. 2.7 g/cm³ (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
Shear strength acc. DIN EN 12797	250 - 300 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 Cartridge: min. 3 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

Applications

BrazeTec D 4900.1 is a dosable brazing paste for use with brazing machines. It contains flux and a low melting free flowing silver brazing alloy.
The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium.
The dosable brazing paste BrazeTec D 4900.1 is suitable for all common brazing methods, like torch brazing, furnace brazing and induction brazing.
Typical applications are found e.g. in the tool industry.

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

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@umicore.com