



Brazing alloy BrazeTec 1204 U

TD EN 1204 U REV. 1

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
12	48	39,85	-	0,15	-	-	-	-	Ag 212	AG 207	-

Technical data:

Melting range (°C)	800-830
Working temperature (°C)	830
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	8,5
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235:380; with E 295:430
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications

Refrigeration and air conditioning industry, plumbing technology

Operating conditions

Silver based brazing alloy, flux coated. Excellent flow, capillarity and mechanical strength characteristics. Used for brazing any steels, copper and copper alloys, as well as nickel and nickel alloys.

Recommended fluxes

Flux as coating of the DIN EN 1045 FH 10 rod. Flux residues are corrosive and water-soluble, we suggest to remove them with water and / or mechanical brushing.

Heat sources

Flame, induction heating

Delivery forms

Coated rods

Notes

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