



Brazing alloy BrazeTec 1204

TD EN 1204 REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
12	48	39,8 5	-	0,15	-	-	-	-	Ag 212	AG 207	B-Cu48ZnAg(Si)- 800/830

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)	8,3
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, air conditioning and electrical industry, plumbing technology

Operating conditions

Silver based brazing alloy with 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

N1/T, Super 1, N2/E, H paste, H sprayable, RS/A, FN/E, D 98, H 280

Heat sources

Induction heating, flame, furnace in vacuum and under protective atmosphere

Delivery forms

Wire, rods, ribbon, rings, preforms, powder

Notes

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Italbras S.p.A.

Strada del Balsego, 6 – 36100 Vicenza (I)

info@italbras.it - www.italbras.it -

Tel. +39 0444.3475-00 / Fax +39 0444.3475-01