Brazing alloy BrazeTec 2009

Composition (% in weight)

<table>
<thead>
<tr>
<th>Ag</th>
<th>Cu</th>
<th>Zn</th>
<th>Sn</th>
<th>Si</th>
<th>P</th>
<th>Mn</th>
<th>Ni</th>
<th>Other</th>
<th>ISO 17672:2010</th>
<th>EN 1044:1999</th>
<th>ISO 3677</th>
</tr>
</thead>
<tbody>
<tr>
<td>20</td>
<td>44</td>
<td>35.8</td>
<td>5</td>
<td>-</td>
<td>0.15</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>AG 206</td>
<td>-</td>
<td></td>
</tr>
</tbody>
</table>

Technical data:

- Melting range (°C) 690-810
- Working temperature (°C) 810
- Melting range according to DSC measurement (°C) -
- Min. brazing temperature (°C) -
- Electrical conductivity (m/Ω mm²) 10.6
- Elongation % 25
- Density (g/cm³) 8.7
- Shear strength (MPa) -
- Tensile strength DIN EN 12797 (MPa) with St 37: 380; with St 50: 430
- Operating temperature of brazed joint (min/max) ± (°C) 200

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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