Brazing alloy BrazeTec 3076 U

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>30</td>
<td>36</td>
<td>32</td>
<td>2</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>Ag 130</td>
<td>AG 107</td>
<td>-</td>
</tr>
</tbody>
</table>

Technical data:

- **Melting range (°C):** 665-755
- **Working temperature (°C):** 740
- **Melting range according to DSC measurement (°C):** 670-755
- **Min. brazing temperature (°C):** 755
- **Electrical conductivity (m/Ω mm²):** -
- **Elongation %:** -
- **Density (g/cm³):** 8.8
- **Shear strength (MPa):** -
- **Tensile strength DIN EN 12797 (MPa):** with S 235: 360; with E 295: 480
- **Operating temperature of brazed joint (min/max) ± (°C):** 200

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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