



Brazing alloy BrazeTec 3076

TD EN 3076 REV. 4

Composition (% in weight)

| Ag | Cu | Zn | Sn | Si | P | Mn | Ni | Other | ISO 17672:2010 | EN 1044:1999 | ISO 3677 |
|----|----|----|----|----|---|----|----|-------|----------------|--------------|----------------------|
| 30 | 36 | 32 | 2 | - | - | - | - | - | Ag 130 | AG 107 | B-Cu36AgZnSn 665/755 |

Technical data:

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|--|----------------------------------|
| 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 mm ²) | - |
| Elongation % | - |
| Density (g/cm ³) | 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, 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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