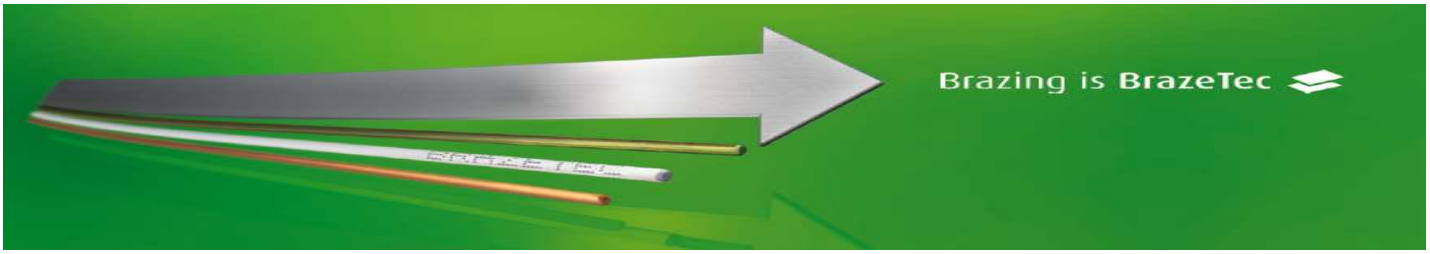
TECHNICAL DATASHEET



Brazing alloy BrazeTec 3476 U

TD EN 3476 U REV. 2

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
34	36	27,5	2,5	-	-	-	-	-	Ag 134	AG 106	-

Technical data:

Melting range (°C)	630-730
Working temperature (°C)	710
Melting range according to DSC measurement (°C)	655-745
Min. brazing temperature (°C)	745
Electrical conductibility (m/Ω mm²)	14
Elongation %	11
Density (g/cm^3)	8,9
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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