



Brazing alloy BrazeTec 3476

TD EN 3476 REV. 5

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	B-Cu36AgZnSn 630/730

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 conductivity (m/Ω mm ²)	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, 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

Brazetec 3476 is approved and registered by DVGW, as meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German Association of Gas and Water).

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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

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