TECHNICAL DATASHEET

Brazing alloy BrazeTec 4076
TD EN 4076 REV. 4

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>40</td>
<td>30</td>
<td>28</td>
<td>2</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>Ag 140</td>
<td>AG 105</td>
<td>B-Ag40CuZnSn-650/710</td>
</tr>
</tbody>
</table>

Technical data:

- Melting range (°C) -
- Working temperature (°C) -
- Melting range according to DSC measurement (°C) 660-720
- Min. brazing temperature (°C) 720
- Electrical conductivity (m/Ω mm²) -
- Elongation % -
- Density (g/cm³) 9
- Shear strength (MPa) -
- Tensile strength DIN EN 12797 (MPa) with S 235: 350; with E 295: 430
- Operating temperature of brazed joint (min/max) ± (°C) 200

Applications
Air conditioning, refrigeration and electrical industry, plumbing technology, precision metal parts, fashion accessories, automotive, spectacle frames (optics)

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
- The information reported in this document about our products and equipment as well as our systems and procedures are based on our research and our experience in the field of applied engineering and are merely recommendations.
- Italbras S.p.A. declines any liability for any loss, damage or injury howsoever arising (including any claim brought by third parties) as a result of the use of such information. Each warranty of suitability of our products and their use within the production processes of the user, must be agreed in written form. We reserve the right to make technical modifications to this document in the course of our product development.

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