



Brazing alloy BrazeTec 4085

TD EN 4085 REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
40	30	28	-	-	-	-	2	-	Ag 440	-	-

Technical data:

Melting range (°C)	660-780
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	9
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications

Tool industry

Operating conditions

Silver based brazing alloy with excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium.

Recommended fluxes

H spezial, H 285, H paste, H 280, H 80

Heat sources

Induction heating, flame, furnace

Delivery forms

Wire, rods, ribbon, rings, preforms

Notes

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