



## Brazing alloy BrazeTec 4404 U

TD EN 4404 U REV. 1

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
44	30	26	-	-	-	-	-	-	Ag 244	AG 203	-

### Technical data:

Melting range (°C)	675 - 735
Working temperature (°C)	730
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm <sup>2</sup> )	11,2
Elongation %	25
Density (g/cm <sup>3</sup> )	9,1
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235:400; 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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