



Brazing alloy BrazeTec 4404

TD EN 4404 REV. 3

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
44	30	26	-	-	-	-	-	-	-	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 ²)	11,2
Elongation %	25
Density (g/cm ³)	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

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

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 spezial, H 280, H 80, H 285

Heat sources

Induction heating, flame, furnace in vacuum and under protective atmosphere

Delivery forms

Wire, rods, ribbon, rings, preforms, powder

Notes

Brazetec 4404 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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