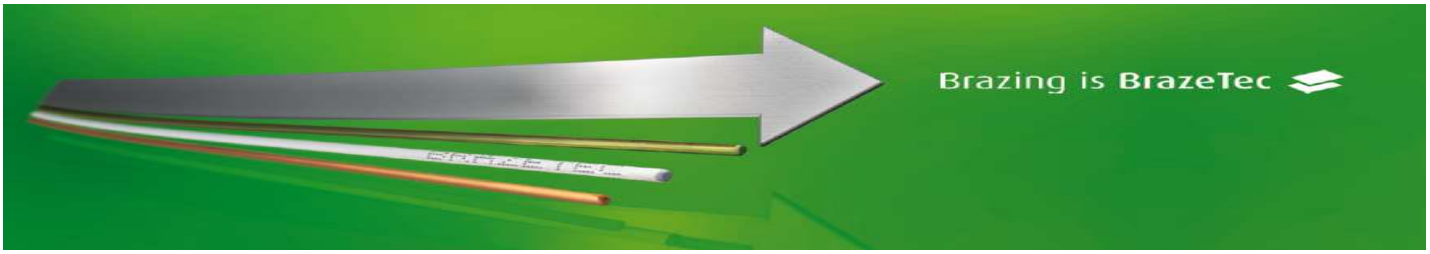
TECHNICAL DATASHEET



Brazing alloy BrazeTec 4576

TD EN 4576 REV. 5

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
45	27	25,5	2,5	-	-	-	-	-	Ag 145	AG 104	B-Ag45CuZnSn-640/680

Technical data:

Melting range (°C)	640-680
Working temperature (°C)	670
Melting range according to DSC measurement (°C)	645-695
Min. brazing temperature (°C)	695
Electrical conductibility (m/Ω mm²)	13
Elongation %	23
Density (g/cm^3)	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
Brazetec 4576 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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