



## 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 conductivity (m/Ω mm <sup>2</sup> )	13
Elongation %	23
Density (g/cm <sup>3</sup> )	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).

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. cannot foresee all circumstances in which these information and our products will be used, therefore the user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility.

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.