



Brazing alloy BrazeTec 4900A

TD EN 4900 A REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
49	27,5	20,5	-	-	-	2,5	0,5	-	-	-	-

Technical data:

Melting range (°C)	670-690
Working temperature (°C)	690
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	4
Elongation %	-
Density (g/cm ³)	8,9
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	250-300
Operating temperature of brazed joint (min/max) ± (°C)	200

Applications

Tool industry

Operating conditions

Silver based alloy with improved fluidity compared to 4900 alloy. Excellent capillarity and mechanical strength characteristics. Suitable for brazing cemented carbides and materials which are difficult to wet such as tungsten, molybdenum, tantalum and chrome. Narrow range solidus-liquidus.

Recommended fluxes

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

Heat sources

Induction heating, flame

Delivery forms

Wire, rods, ribbon

Notes

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