



Brazing alloy BrazeTec 4

TD EN 4 REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	DIN EN ISO 9453:2006
3,3	-	-	Rest	-	-	-	-	-	-	-	702

Technical data:

Melting range (°C)	221 - 230
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Electrical conductivity (m/Ωmm ²)	7,5
Elongation %	-
Density (g/cm ³)	7,3
Shear strength DIN EN 12797 (MPa)	Cu: 30 ; Brass: 20
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications

Plumbing technology, electrical industry

Operating conditions

Tin based brazing alloy, free from antimony and lead. Excellent flow, capillarity and mechanical strength characteristics. Used for joining copper, brass and red brass. BrazeTec 4 meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German Association of Gas and Water).

BrazeTec 4 is approved and registered by DVGW (DV-0106CM0046) and has been awarded by the Gütegemeinschaft Kupferrohr e.V. (The copper tube Manufacturers Quality Association). Therefore it is suitable for copper pipes installations for plumbing system.

Recommended fluxes

Soldaflux 7000

Heat source

Flame, induction heating, resistance

Forms

Wire

Notes

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