



Brazing alloy BrazeTec 6009

TD EN 6009 REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
60	30	-	10	-	-	-	-	-	Ag 160	AG 402	B-Ag60CuSn-600/730

Technical data:

Melting range (°C)	600-730
Working temperature (°C)	720
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	8,7
Elongation %	35
Density (g/cm ³)	9,8
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235: 390; with E 295: 460
Operating temperature of brazed joint (min/max) ± (°C)	200

Applications

Air conditioning and electrical industry

Operating conditions

Silver based brazing alloy with excellent flow, capillarity and mechanical strength characteristics. Used for brazing any steels, stainless steel, copper and copper alloys, as well as nickel and nickel based alloys. Brazing procedures in vacuum should be carried out at temperatures which not exceed 900 °C to avoid evaporation of silver.

Recommended fluxes

H paste, H spezial, H 280, H 285

Heat sources

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

Delivery forms

Wire, rods, ribbon, rings

Notes

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