



Brazing alloy in paste BrazeTec D 4900

TD EN D 4900 REV. 2

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Oth er	ISO 17672:201 0	EN 1044:1999	ISO 3677
49	16	23	-	-	-	7,5	4,5	-	Ag 449	AG 502	-

Technical data:

Melting range (°C)	680-705
Working temperature (°C)	690
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	200
Tensile strength DIN EN 12797 (MPa)	250-300
Alloy density (g/cm ³)	8,9
Paste density (g/cm ³)	2,7 at 20 °C
Metal content (%) of total weight	65
Grain size of brazing alloy powder (µm)	< 106
Viscosity (dPas)	1100-1300 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Braze Tec Agent P
Flux type within the paste	FH10
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

Applications

Tool industry

Operating conditions

Silver based alloy with excellent flow, capillarity and mechanical strength characteristics. Dosable for automated brazing process. Suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium.

Heat source

Flame, induction heating, furnace

Standard packaging

Jar

Residues are corrosive and have to be removed with water and mechanical rubbing.

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