



## Brazing alloy BrazeTec 4404

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
44	30	26	-	-	-	-	-	-	-	AG 203	-

### Technical data:

Melting range (°C)	675 - 735
Working temperature (°C)	730
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm <sup>2</sup> )	11,2
Elongation %	25
Density (g/cm <sup>3</sup> )	9,1
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235:400; with E 295:480
Operating temperature of brazed joint (min/max) ± (°C)	200

### Applications

Air conditioning, refrigeration and electrical industry, plumbing technology, automotive, spectacle frames (optics), precision metal parts, fashion accessories, tool industry

### 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, RS/A, FN/E, D 98, H spezial, H 280, H 80, H 285

### Heat sources

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

### Delivery forms

Wire, rods, ribbon, rings, preforms, powder

### Notes

Brazetec 4404 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).

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