



Brazing alloy BrazeTec 4076 U

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044	ISO 3677
40	30	28	2	-	-	-	-	-	Ag 140	AG 105	-

Technical data:

Melting range (°C)	650 - 710
Working temperature (°C)	690
Melting range according to DSC measurement (°C)	660-720
Min. brazing temperature (°C)	720
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	9
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235: 350; with E 295: 430
Operating temperature of brazed joint (min/max) ± (°C)	200

Applications

Refrigeration and air conditioning industry, plumbing technology.

Operating conditions

Silver based brazing alloy, flux coated. 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

Flux as coating of the ISO 18496 FH 10 rod. Flux residues are corrosive and water-soluble, we suggest to remove them with water and / or mechanical brushing.

Heat sources

Flame, induction heating.

Delivery forms

Coated rods.

Notes

AWS A5.8 (ASME IX): BAg-28.

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