



Brazing alloy BrazeTec 6009 U

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044	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

Refrigeration and air conditioning industry, electrical industry

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-18

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