



Technical Data Sheet BrazeTec 4576



TD BT 0005 E.01

Standard

AG 104 acc. DIN EN 1044 (L-Ag45Sn acc. DIN 8513)
B-Ag45CuZnSn 640/680 acc. ISO 3677

Nominal composition in wt.-% Ag 45; Cu 27; Zn 25,5; Sn 2,5
Permitted impurities (weight-%):
Al 0,001; Bi 0,030; Cd 0,030; P 0,008; Pb 0,025; Si 0,05; Total impurities 0,15

Technical data

Melting range	app. 640 - 680 °C (DIN EN 1044)
Working temperature	app. 670 °C
Density	app. 9,2 g/cm ³
Tensile strength acc. DIN 8525	with St 37: 350 MPa; with St 50: 430 MPa
Elongation	app. 10%
Electrical Conductivity	app. 13,0 m/ Ωmm ²
Operating temperature of brazed joint	max. 200 °C (without loss in strength)

Standard delivery form*

Wire: 1,0 - 1,5 - 2,0 mm Ø

Rods: 1,0 - 1,5 - 2,0 mm Ø, 500 mm length

Ribbon: 0,1/ 0,2/ 0,3/ 0,4 mm thickness and 70 mm width

Preforms: rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

*Other delivery forms upon request

Application

BrazeTec 4576 is a low melting silver based brazing alloy with excellent flow characteristics. It can be used for brazing any steels, copper and copper based alloys as well as for nickel and nickel based alloys.

It can be used for flame or induction brazing procedures.

Typical applications are found e.g. in automotive and in the electric industry.

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