



Technical Data Sheet BrazeTec CoMet 4576 U



TD BT 0403 E.01

Standard

Brazing Alloy: AG 104 acc. DIN EN 1044 (L-Ag45Sn acc. DIN 8513)
B-Ag45CuZnSn 640/680 acc. ISO 3677
Flux: Type FH10 acc. DIN EN 1045

Brazing Alloy

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 of brazing alloy

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*

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

*Other dimensions on request

Application

BrazeTec CoMet 4576 U is a flux coated low melting silver based brazing alloy with excellent flow characteristics. The flux residues are corrosive and have to be removed. 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 brazing with flame.

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

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