



Technical Data Sheet BrazeTec CoMet 3476 U



TD BT 0405 E.01

Standard

Brazing Alloy: AG 106 acc. DIN EN 1044 (L-Ag34Sn acc. DIN 8513)
B-Cu36AgZnSn 630/730 acc. ISO 3677
Flux: Type FH10 acc. DIN EN 1045

Brazing Alloy

Nominal composition in wt.-% Ag 34; Cu 36; Zn 27,5; 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

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|---------------------------------------|--|
| Melting range | app. 630 - 730 °C (DIN EN 1044) |
| Working temperature | app. 710 °C |
| Density | app. 9,0 g/cm ³ |
| Tensile strength acc. DIN 8525 | with St 37: 360 MPa; with St 50: 480 MPa |
| Elongation | app. 12% |
| Electrical Conductivity | app. 14,0 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 3476 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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