

Standard

Brazing Alloy: ISO 17672 (DIN EN 1044)	Ag 134 (AG 106)
Flux: DIN EN 1045 AWS A5.31-92R	FH10 FB3-F

Brazing Alloy

Nominal composition [wt.-%]	Ag 34; Cu 36; Zn 27.5; Sn 2.5
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
Max. impurities [wt.-%]	0.15

Technical data

Melting range acc. ISO 17672	approx. 630 - 730 °C
Melting range acc. Measurement	approx. 655 - 745 °C (DSC-measurement)
Brazing temperature	min. 745 °C
Density	approx. 8.9 g/cm ³
Tensile strength acc. DIN EN 12797	with S235: 360 MPa; with E295: 480 MPa
Elongation at rupture	approx. 11 %
Electrical Conductivity	approx. 14.0 m/ Ωmm ²
Operating temp. of brazed joint	approx. -200 °C to +200 °C (without loss in strength)
Shelf life (flux)	min. 6 months, but only at storage temperatures between +5 to +30 °C. Avoid rapid changes in temperature

Standard delivery forms*

Rods:	1.5 - 2.0 mm Ø, 500 mm length
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*Other delivery forms upon request

Applications

BrazeTec CoMet 3476U 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. BrazeTec CoMet 3476U meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German association of Gas and Water).

Typical applications are found e.g. in the plumbing trade, in the refrigeration and air conditioning industry, automotive and in the electric industry.

According to the experience, the fluxing activity of fluxes is also given above the date of expiry (in the original sealed packing). Please consider, that e.g. the loss or the absorption of humidity may influence the adherence of the flux coating