



## Technical Data Sheet BrazeTec 3464



TD BT 0203 E.02

### Inhalt

**Cadmium - containing brazing alloy.** Please note the recommendations in our Material Safety Data Sheet.

### Standard

BrazeTec Standard (L-Ag34Cd acc. DIN 8513)  
ISO 3677 B-Ag34ZnCuCd 610/680

### Brazing Alloy

**Nominal composition [wt.-%]** Ag 34; Cu 22; Zn 24; Cd 20  
**Permitted impurities max. [wt.-%]** Al 0,001; Bi 0,030; P 0,008; Pb 0,025; Si 0,05  
**Max. impurities [wt.-%]** 0,15

### Technical data

**Melting range** approx. 610 - 680°C  
**Working temperature** approx. 640°C  
**Density** approx. 9,1 g/cm<sup>3</sup>  
**Tensile strength acc. DIN EN 12797** with: S235: 400 MPa; with: E295: 480 MPa  
**Elongation** approx. 25 %  
**Electrical Conductivity** approx. 15,0  
m/ Ωmm<sup>2</sup>  
**Operating temp. of brazed joint** max. 150 °C (without loss in strength)

### Standard delivery forms\*

**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

### Applications

**BrazeTec 3464** 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 brazing with flame or induction brazing procedures. Typical applications are found e.g. in automotive and in the electric and tool industry.

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