



Technical Data Sheet BrazeTec 4900



TD BT 0016 E.02

Inhalt

Standard

DIN EN 1044
ISO 3677

AG 502 (L-Ag49 acc. DIN 8513)
B-Ag49ZnCuMnNi 680/705

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]
Max. impurities [wt.-%]

Ag 49; Cu 16; Zn 23; Mn 7,5; Ni 4,5
Al 0,001; Bi 0,030; Cd 0,010; P 0,008; Pb 0,025; Si 0,05
0,3

Technical data

Melting range	approx. 680 - 705 °C (DIN EN 1044)
Working temperature	approx. 690 °C
Density	approx. 8,9 g/cm ³
Shear strenght acc. DIN EN 12797	250 - 300 MPa (carbide/steel)
Electrical Conductivity m/ Ωmm ²	approx. 4,0
Operating temp. of brazed joint	max. 200 °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 4900 is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. The reachable strength of the joint depends from the parent metals.

It can be used for brazing with flame or induction brazing procedures.
Typical applications are found e.g. in the tool industry.

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