



## Technical Data Sheet BrazeTec 2002



TD BT 0206 E.02

### Inhalt

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

### Standard

DIN EN 1044  
ISO 3677

AG 309 (L-Ag20Cd acc. DIN 8513)  
B-Cu40ZnAgCd 605/765

### Brazing Alloy

#### Nominal composition [wt.-%]

Ag 20; Cu 40; Zn 25; Cd 15

#### 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. 605 - 765 °C (DIN EN 1044)

Working temperature

approx. 750 °C

Density

approx. 8,8 g/cm<sup>3</sup>

Tensile strength acc. DIN EN 12797

with S235: 350 MPa; with E295: 430 MPa

Electrical Conductivity

approx. 12,0

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 2002** 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 industry.

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