



Technical Data Sheet BrazeTec 4505



TD BT 0201 E.02

Inhalt

Cadmium - containing brazing alloy.

Please note the recommendations in our Material Safety Data Sheet.

Standard

ISO 3677 (L-Ag45Cd acc. DIN 8513)
B-Ag45CdZnCu 605/620

Brazing Alloy

Nominal composition [wt.-%] Ag 45; Cu 17; Zn 18; 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. 620 - 635°C
Working temperature approx. 620 °C
Density approx. 9,4 g/cm³
Tensile strength acc. DIN EN 12797 with: S235: 410 MPa; with: E295: 510 MPa
Elongation approx. 25 %
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 4505 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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