



Technical Data Sheet BrazeTec CoMet 2002 U



TD BT 0503 E.02

Inhalt

Cadmium - containing brazing alloy.

Please note the recommendations in our Material Safety Data Sheet.

Standard

Brazing Alloy:

DIN EN 1044

ISO 3677

Flux:

US-Standard ANSI/AWS A5.8

AG 309 (L-Ag20Cd acc. DIN 8513)

B-Cu40ZnAgCd 605/765

Type FH10

Brazing Alloy

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

Ag 20; Cu 40; Zn 25; Cd 15

Al 0,001; Bi 0,030; P 0,008; Pb 0,025; Si 0,05

0,15

Technical data

Melting range

Working temperature

Density

Tensile strength acc. DIN EN 12797

Electrical Conductivity

m/ Wmm²

Operating temp. of brazed joint

approx. 605 - 765 °C (DIN EN 1044)

approx. 750 °C

approx. 8,8 g/cm³

with S235: 350 MPa; with E295: 430 MPa

approx. 12,0

max. 150 °C (without loss in strength)

Standard delivery forms *

Rods:

1,5 - 2,0 mm Ø, 500 mm length

*Other delivery forms upon request

Applications

BrazeTec CoMet 2002 U is a flux coated low melting silver based brazing alloy with excellent flow characteristics. The flux residues are corrosive have to be removed. 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.

Typical applications are found e.g. in the electric and automotive industry.

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