



Technical Data Sheet BrazeTec CoMet 3476 U



TD BT 0405 E.02

Inhalt

Standard

Brazing Alloy:	
DIN EN 1044	AG 106 (L-Ag34Sn acc. DIN 8513)
ISO 3677	B-Cu36AgZnSn 630/730
Flux:	
US-Standard ANSI/AWS A5.8	Type FH10

Brazing Alloy

Nominal composition [wt.-%]	Ag 34; Cu 36; Zn 27,5; Sn 2,5
Permitted impurities max. [wt.-%]	Al 0,001; Bi 0,030; Cd 0,010; P 0,008; Pb 0,025; Si 0,05
Max. impurities [wt.-%]	0,15

Technical data

Melting range	approx. 630 - 730 °C (DIN EN 1044)
Working temperature	approx. 710 °C
Density	approx. 9,0 g/cm ³
Tensile strength acc. DIN EN 12797	with S235: 360 MPa; with E295: 480 MPa
Elongation	approx. 12 %
Electrical Conductivity m/ Wmm ²	approx. 14,0
Operating temp. of brazed joint	max. 200 °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 3476 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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