



Technical Data Sheet BrazeTec CoMet 4404 U



TD BT 0408 E.02

Inhalt

Standard

Brazing Alloy:
DIN EN 1044 AG 203 (L-Ag44 acc. DIN 8513)
ISO 3677 B-Ag44CuZn-675/735
Flux:
US-Standard ANSI/AWS A5.8 Type FH10

Brazing Alloy

Nominal composition [wt.-%] Ag 44; Cu 30; Zn 26
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. 675 - 735 °C (DIN EN 1044)
Working temperature approx. 7300 °C
Density approx. 9,1 g/cm³
Tensile strength acc. DIN EN 12797 with S235: 400 MPa; with E295: 480 MPa
Elongation approx. 25 %
Electrical Conductivity approx. 11,2
m/ Wmm²
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 4404 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 plumbing, in the electric and automotive industry.

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Dokumenten-Informationen

Dokument	Helmut Ries/Wolfgang/LNWW		
Eigentümer:			
Autor(en):	Helmut Ries/Wolfgang/LNWW	Erstell-Datum:	16.07.2001 (Urversion)
	Daniel Schnee/Wolfgang/LNWW		07.10.2005 (act.Version)