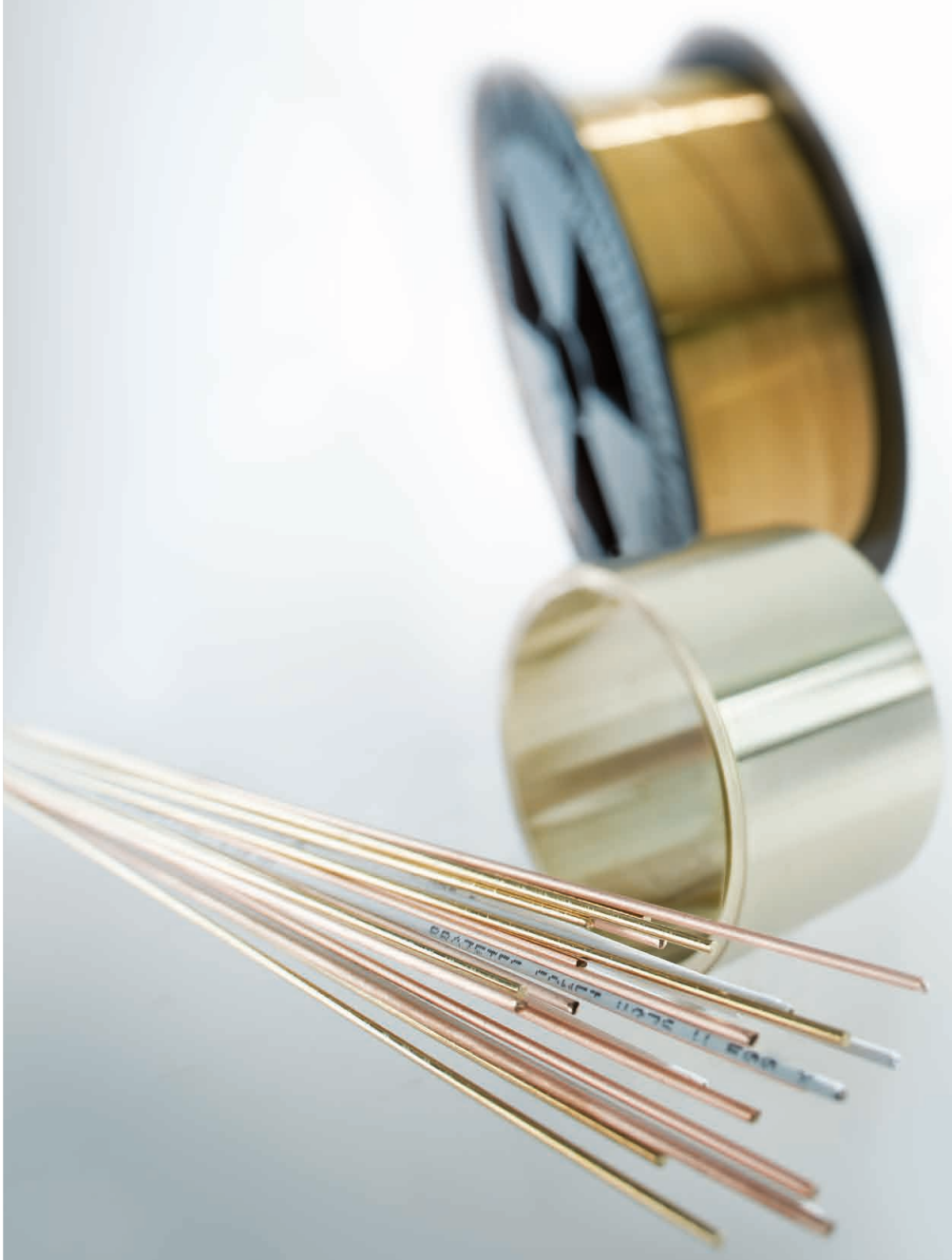


# BRAZETEC Silver Brazing Alloys





## / BRAZETEC Silver Brazing Alloys, Cadmium Free

The silver brazing alloys shown on this page are generally capable of being used for operating temperatures from -200 °C to +200 °C. They can be used with any type of steel, copper and copper alloy, also nickel and nickel alloy. Other brazing alloys are available on request or can be customised.

Name	Composition by Weight-%				Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Density	ISO 17672	Shear Strength acc. to DIN EN 12797 min.	Available Forms			
	Ag	Cu	Zn	Misc.	in °C	in °C	in °C	in g/cm <sup>3</sup>		in MPa on S 235				
BrazeTec 5662	56	19	17	5 Sn/3 Ga	605 – 630	–	630	9.3	–	150	•	•	–	–
BrazeTec 5600	56	22	17	5 Sn	630 – 655	620 – 655	655	9.4	Ag 156	150	•	•	•	•
BrazeTec 5507	55	21	22	2 Sn	650 – 670	630 – 660	670	9.3	Ag 155	150	•	•	•	•
BrazeTec 4576	45	27	25.5	2.5 Sn	645 – 695	640 – 680	695	9.1	Ag 145	150	•	•	•	•
BrazeTec 4076	40	30	28	2 Sn	665 – 725	650 – 710	725	9.0	Ag 140	150	•	•	•	•
BrazeTec 3476	34	36	27.5	2.5 Sn	655 – 745	630 – 730	745	8.9	Ag 134	150	•	•	•	•
BrazeTec 3076	30	36	32	2 Sn	675 – 760	665 – 755	760	8.8	Ag 130	150	•	•	–	•
BrazeTec 2576	25	40	33	2 Sn	680 – 775	680 – 760	775	8.8	Ag 125	150	•	•	–	•
BlueBraze 2410	24	43.7	20	0.3 Si	690 – 750	–	750	8.4	–	150	•	•	–	•
BrazeTec 4404	44	30	26	–	675 – 735	675 – 735	735	9.1	Ag 244	150	•	•	•	•
BrazeTec 3075	30	38	32	–	700 – 775	680 – 765	775	8.8	Ag 230	150	•	•	•	•
BrazeTec 2500	25	40	35	–	715 – 790	700 – 790	790	8.7	Ag 225	150	•	•	–	•
BrazeTec 2009	20	44	35.8	0.15 Si	730 – 810	–	810	8.6	Ag 220	150	•	•	–	•

Most alloys can be supplied with 0.15% Si

## / BRAZETEC CoMet – Brazing Rods, Cadmium Free & Flux Coated

BrazeTec offers the following cadmium free brazing alloys from its comprehensive range of products under the name of CoMet (coated metal) as flux coated rods as well. These are naturally free from harmful solvents, plastics and boric acid. The flux is equivalent to the type FH 10 in accordance with DIN ISO 18496 and is boracic acid free. The respective instructions for the use of cadmium free brazing alloys are effective for its application. The silver content by weight of the coated brazing rod is lower than the silver content of a bare brazing rod because of the flux coating. The content of the bare brazing rod of course meets the composition found in cadmium free brazing alloys. BrazeTec CoMet coated rods are available with different thickness ratio of flux coating and core wire in the range of 1.3-2.4 as standard according to customer requirements. Other brazing alloys with flux coating are also available on request.



Name	Melting Range acc. to DSC	Brazing Temp. min.	Available Forms
	in °C	in °C	
BrazeTec CoMet 5600 U	630 – 655	655	•
BrazeTec CoMet 4576 U	645 – 695	695	•
BrazeTec CoMet 4404 U	675 – 735	735	•
BrazeTec CoMet 4076 U	665 – 725	725	•
BrazeTec CoMet 3476 U	655 – 745	745	•
BrazeTec CoMet 3076 U	675 – 760	760	•
BlueBraze CoMet 2410 U	690 – 750	750	•
BrazeTec CoMet 2009 U	730 – 810	810	•

Most alloys can be supplied with 0.15% Si

