



Brazing alloy BrazeTec 4911

TD EN 4911 REV. 0

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
39	Rest	-	-	-	-	-	-	31 (Zn+Ni+Mn)	-	-	-

Technical data:

Melting range (°C)	670-720
Working temperature (°C)	710
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	9
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications

Tool industry

Operating conditions

Silver based brazing alloy with excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium.

Recommended fluxes

H spezial, H 285, H paste, H 280, H 80

Heat sources

Induction heating, flame

Delivery forms

Wire, rods, ribbon, rings, preforms

Notes

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