



## Brazing alloy BrazeTec 2009

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
20	44	35,85	-	0,15	-	-	-	-	-	AG 206	-

### Technical data:

Melting range (°C)	690-810
Working temperature (°C)	810
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm <sup>2</sup> )	10,6
Elongation %	25
Density (g/cm <sup>3</sup> )	8,7
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with St 37: 380; with St 50: 430
Operating temperature of brazed joint (min/max) ± (°C)	200

### Applications

Refrigeration, air conditioning and electrical industry, plumbing technology

### Operating conditions

Silver based brazing alloy with excellent flow, capillarity and mechanical strength characteristics. Used for brazing any steels, copper and copper alloys, as well as nickel and nickel alloys.

### Recommended fluxes

N1/T, Super 1, N2/E, H paste, RS/A, FN/E, D 98, H 280

### Heat sources

Induction heating, flame, furnace in vacuum and under protective atmosphere

### Delivery forms

Wire, rods, ribbon, rings, preforms, powder

### Notes

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