



## Brazing alloy BrazeTec 4504

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
45	30	25	-	-	-	-	-	-	Ag 245	-	-

### Technical data:

Melting range (°C)	665-745
Working temperature (°C)	745
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm <sup>2</sup> )	-
Elongation %	-
Density (g/cm <sup>3</sup> )	9,2
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	200

### Applications

Air conditioning, refrigeration and electrical industry, plumbing technology, automotive, spectacle frames (optics), precision metal parts, fashion accessories, tool industry

### 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 spezial, H 280, H 80, H 285

### 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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