



Brazing alloy BrazeTec 4576

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
45	27	25,5	2,5	-	-	-	-	-	Ag 145	AG 104	B-Ag45CuZnSn-640/680

Technical data:

Melting range (°C)	640-680
Working temperature (°C)	670
Melting range according to DSC measurement (°C)	645-695
Min. brazing temperature (°C)	695
Electrical conductivity (m/Ω mm ²)	13
Elongation %	23
Density (g/cm ³)	9,1
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235: 350; with E 295: 430
Operating temperature of brazed joint (min/max) ± (°C)	200

Applications

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

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

Brazetec 4576 is approved and registered by DVGW, as meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German Association of Gas and Water).

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