



## Brazing alloy BrazeTec 4

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
3,2	-	-	Rest	-	-	-	-	-	-	-	S-Sn97Ag3

### Technical data:

Melting range (°C)	221-224
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm <sup>2</sup> )	7,5
Elongation %	-
Density (g/cm <sup>3</sup> )	7,3
Shear strength (MPa)	with St37: 25;Cu: 30 ; Brass: 20
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	-

### Applications

Plumbing technology, electrical industry

### Operating conditions

Tin based brazing alloy, free from antimony and lead. Excellent flow, capillarity and mechanical strength characteristics. Used for joining copper, brass and red brass. BrazeTec 4 meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German Association of Gas and Water). BrazeTec 4 is approved and registered by DVGW (DV-0106CM0046) and has been awarded by the Gütegemeinschaft Kupferrohr e.V. (The copper tube Manufacturers Quality Association). Therefore it is suitable for copper pipes installations for plumbing system.

### Recommended fluxes

Soldaflux 7000

### Heat sources

Flame, induction heating, resistance

### Delivery forms

Wire

### Notes

DIN EN ISO 9453: 702

The information reported in this document about our products and equipment as well as our systems and procedures are based on our research and our experience in the field of applied engineering and are merely recommendations. Italbras S.p.A. cannot foresee all circumstances in which these information and our products will be used, therefore the user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. Italbras S.p.A. declines any liability for any loss, damage or injury howsoever arising (including any claim brought by third parties) as a result of the use of such information. Each warranty of suitability of our products and their use within the production processes of the user, must be agreed in written form. We reserve the right to make technical modifications to this document in the course of our product development.

### Italbras S.p.A.

Strada del Balsego, 6 – 36100 Vicenza (I)  
[info@italbras.it](mailto:info@italbras.it) - [www.italbras.it](http://www.italbras.it) -  
 Tel. +39 0444.3475-00 / Fax +39 0444.3475-01