TECHNICAL DATASHEET

Brazing alloy in paste Degufit 4000

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	EN ISO 9453	EN 1044:1999	ISO 3677
3,2	-	-	Rest	-	-	-	-	-	702 for metallic part	-	S-Sn97Ag3

Technical data:

Melting range (°C)	221-224
Working temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	-
Tensile strength DIN EN 12797 (MPa)	-
Alloy density (g/cm^3)	7,3
Paste density (g/cm^3)	2,4
Metal content (%) of total weight	60
Chloride content (%)	Max. 9
Viscosity (dPas)	300-500 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Water
Flux type within the paste	DIN EN 29454-1: 3.1.1
Shelf life	24 months, but only in the original sealed container at storage temperatures between +5° to 30°C

Applications
Plumbing technology, electrical industry

Operating conditions
Tin based brazing alloy. Excellent flow, capillarity and mechanical strength characteristics. Used for joining copper, copper alloys, steel, as well as nickel and nickel alloys. Degufit 4000 meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German Association of Gas and Water). It is approved and registered by DVGW (DV-0101AU2259) and has been awarded by the Gütegemeinschaft Kupferrohr e.V. (The coppertube Manufactures Quality Association). Therefore it is suitable for copper pipes installations for plumbing system.

Heat source
Flame, induction heating

Standard packaging
250 gr jar with brush

Notes
Clean the joint from metal oxides through mechanical rubbing. Apply a thin layer of paste on the cleaned tube surface. After assembling the joint, heat with flame or resistance till fillet appears. During brazing process, add wire alloy BrazeTec 4 in wire. Paste residues must be removed by mechanical rubbing or washing with water. Potable water lines have to be rinsed referring DIN 1988 in.

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