



Brazing alloy BrazeTec 4076

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044	ISO 3677
40	30	28	2	-	-	-	-	-	Ag 140	AG 105	B-Ag40CuZnSn-650/710

Technical data:

Melting range (°C)	650 - 710
Working temperature (°C)	690
Melting range according to DSC measurement (°C)	660-720
Min. brazing temperature (°C)	720
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	9
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

AWS A5.8 (ASME IX): BAg-28.

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