Technical Data Sheet
BrazeTec 4900

TD BT 0016 E.01

Standard

AG 502 acc. DIN EN 1044 (L-Ag49 acc. DIN 8513)
B-Ag49ZnCuMnNi 680/705 acc. ISO 3677

Nominal composition in wt.-%   Ag 49; Cu 16; Zn 23; Mn 7,5; Ni 4,5
Permitted impurities (weight-%):
Al 0,001; Bi 0,030; Cd 0,030; P 0,008; Pb 0,025; Si 0,05; Total impurities 0,3

Technical data

Melting range	app. 680 - 705 °C (DIN EN 1044)
Working temperature	app. 690 °C
Density	app. 8,9 g/cm^3
Shear strength	250 - 300 MPa (cemented carbide/steel)
Electrical Conductivity	app. 4,0 m/ Ωmm^2
Operating temperature of brazed joint	max. 200 °C (without loss in strength)

Standard delivery form*

Wire: 1,0 - 1,5 - 2,0 mm Ø

Rods: 1,0 - 1,5 - 2,0 mm Ø, 500 mm length

Ribbon: 0,1/ 0,2/ 0,3/ 0,4 mm thickness and 70 mm width

Preforms: rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

*Other delivery forms upon request

Application

BrazeTec 4900 is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. The reachable strength of the joint depends from the parent metals.

It can be used for brazing with flame or induction brazing procedures.

Typical applications are found e.g. in the tool industry.