Technical Data Sheet BrazeTec 6009

Standard	
ISO 17672	Ag 160
(DIN EN 1044)	*(AG 402)*
(AWS 5.8)	*(BAg-18)*
Nominal composition [wt.-%]	Ag 60; Cu 30; Sn 10
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
Max. impurities [wt.-%]	0.15

Technical data	
Melting range	approx. 600 - 730 °C
Working temperature	approx. 720 °C
Density	approx. 9.8 g/cm³
Tensile strength acc. DIN EN 12797	with S235: 390 MPa; with E295: 460 MPa
Elongation	approx. 35 %
Electrical Conductivity	approx. 8.7 m/ Ωmm²
Operating temp. of brazed joint	approx. -200 °C to +200 °C (without loss in strength)

Standard delivery forms*	
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

Applications

BrazeTec 6009 can be used for brazing unalloyed, low and high alloyed, copper and copper based alloys as well as for nickel and nickel based alloys. It can be used for brazing with flame or induction brazing procedures. It is well suitable for brazing under protective atmosphere or under vacuum. The brazing temperature in the furnace is determined by the parent metals. Brazing procedures under vacuum should be done at temperatures not much above 900 °C to avoid evaporation of silver as far as possible.
Typical applications are found e.g. in the electric and air conditioning industry.