Technical Data Sheet BrazeTec CoMet 2009U

Standard

Brazing Alloy:	
BrazeTec Standard	
(DIN EN 1044)	*(AG 206)*
(ISO 3677)	*(B-Cu44ZnAg(Si)-690/810)*
Flux:	
US-Standard ANSI/AWS A5.8	FH10

Brazing Alloy

Nominal composition [wt.-%]	Ag 20; Cu 44; Zn 36; Si 0.15
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025
max. impurities [wt.-%]	0.15

Technical data

Melting range	approx. 690 - 810 °C
Working temperature	approx. 810 °C
Density	approx. 8.7 g/cm³
Tensile strength acc. DIN EN 12797	with S235: 380 MPa; with E295: 430 MPa
Elongation	approx. 25 %
Electrical Conductivity	approx. 10.6 m/ Ωmm²
Operating temp. of brazed joint	approx. -200 °C to +200 °C (without loss in strength)
Shelf life (flux)	min. 6 months, but only at storage temperatures between +5 to +30 °C. Avoid rapid changes in temperature

Standard delivery forms*

Rods:	1.5 - 2.0 mm Ø, 500 mm length

*Other delivery forms upon request

Applications

BrazeTec CoMet 2009U is a flux coated low melting silver based brazing alloy with excellent flow characteristics. The flux residues are corrosive have to be removed. It can be used for brazing any steels, copper and copper based alloys as well as for nickel and nickel based alloys.
It can be used for brazing with flame.

Typical applications are found e.g. in the electric and automotive industry.

According to the experience, the fluxing activity of fluxes is also given above the date of expiry (in the original sealed packing). Please consider, that e.g. the loss or the absorption of humidity may influence the adherence of the flux coating

Note for user: The flux residues are corrosive and have to be removed