Technical Data Sheet
BrazeTec 2002

TD BT 0206 E.01

Cadmium - containing brazing alloy. Please note the recommendations in our Material Safety Data Sheet.

Standard

AG 309 acc. DIN EN 1044 (L-Ag20Cd acc. DIN 8513)
B-Cu40ZnAgCd 605/765 acc. ISO 3677

Nominal composition in wt.-% Ag 20; Cu 40; Zn 25; Cd 15
Permitted impurities (weight-%):
Al 0,001; Bi 0,030; P 0,008; Pb 0,025; Si 0,05; Total impurities 0,15

Technical data

Melting range	app. 605 - 765 °C (DIN EN 1044)
Working temperature	app. 750 °C
Density	app. 8,8 g/cm^3
Tensile strength acc. DIN 8525	with St 37: 350 MPa; with St 50: 430 MPa
Electrical Conductivity	app. 12,0 m/ Ωmm^2
Operating temperature of brazed joint	max. 150 °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, lamina, discs, perforated plates

*Other delivery forms on request

Application

BrazeTec 2002 is a low melting silver based brazing alloy with excellent flow characteristics. 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 or induction brazing procedures.

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