

## Technical Data Sheet BrazeTec CoMet 2009U

### Standard

Brazing Alloy:

BrazeTec Standard

(DIN EN 1044)

(ISO 3677)

(AG 206)

(B-Cu44ZnAg(Si)-690/810)

Flux:

US-Standard ANSI/AWS A5.8

FH10

### Brazing Alloy

**Nominal composition [wt.-%]**

Permitted impurities max. [wt.-%]

max. impurities [wt.-%]

Ag 20; Cu 44; Zn 36; Si 0.15

Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025

0.15

### Technical data

Melting range

approx. 690 - 810 °C

Working temperature

approx. 810 °C

Density

approx. 8.7 g/cm<sup>3</sup>

Tensile strength acc. DIN EN 12797

with S235: 380 MPa; with E295: 430 MPa

Elongation

approx. 25 %

Electrical Conductivity

approx. 10.6 m/Ωmm<sup>2</sup>

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

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