

Technical Data Sheet BrazeTec CoMet 5600U

Standard

Brazing Alloy:	
ISO 17672	Ag 156
(DIN EN 1044)	(AG 102)
Flux:	
US-Standard ANSI/AWS A5.8	FH10

Brazing Alloy

Nominal composition [wt.-%]	Ag 56; Cu 22; Zn 17; Sn 5
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 acc. ISO 17672	approx. 620 - 655 °C
Melting range measured	630 – 655 °C (DSC-measurement)
Brazing temperature	approx. 655 °C
Density	approx. 9.4 g/cm ³
Tensile strength acc. DIN EN 12797	with S235: 350 MPa; with E295: 430 MPa
Shear strength acc. DIN EN 12797	
With S235	min. 150 MPa
Elongation	approx. 25 %
Electrical Conductivity	approx. 7.0 m/Ωmm ²
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 5600U 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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