



Technical Data Sheet BrazeTec 6009



TD BT 0023 E.01

Standard

AG 402 acc. DIN EN 1044
B-Ag60CuSn-600/730 acc. ISO 3677

Nominal composition in wt.-% Ag 60; Cu 30; Sn 10
Permitted impurities (weight-%):
Al 0,001; Bi 0,030; Cd 0,030; P 0,008; Pb 0,025; Si 0,05; Total impurities 0,15

Technical data

Melting range	app. 600 - 730 °C (DIN EN 1044)
Brazing temperature	app. 720 °C
Density	app. 9,8 g/cm ³
Tensile strength acc. DIN 8525	with St 37: 390 MPa; with St 50: 460 MPa
Elongation	app. 35%
Electrical Conductivity	app. 8,7 m/ Ωmm ²
Operating temperature of brazed joint	max. 200 °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 6009 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. 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.

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