



# Technical Data Sheet BrazeTec CoMet 4404 U



**TD BT 0408 E.01**

## Standard

Brazing Alloy: AG 203 acc. DIN EN 1044 (L-Ag44 acc. DIN 8513)  
B-Ag44CuZn-675/735 acc. ISO 3677  
Flux: Type FH10 acc. DIN EN 1045

## Brazing Alloy

**Nominal composition in wt.-%** Ag 44; Cu 30; Zn 26

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 to alloy

Melting range	app. 675 - 735 °C (DIN EN 1044)
Working temperature	app. 730 °C
Density	app. 9,1 g/cm <sup>3</sup>
Tensile strength acc. DIN 8525	with St 37: 400 MPa; with St 50: 480 MPa
Elongation	app. 25%
Electrical Conductivity	app. 11,2 m/ Ωmm <sup>2</sup>
Operating temperature of brazed joint	max. 200 °C (without loss in strength)

## Standard delivery form\*

Rods: 1,5 - 2,0 mm Ø, 500 mm length

\*Other demension on request

## Application

BrazeTec CoMet 4404 U 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 plumbing, electric and automotive industry.

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