



TECHNICAL DATA SHEET

Release	0 17.6.2019
Nature of mod.	First issue
Author	RQ
Mod	CPO/ST Rev.2 del 17/06/2019

A.V.Saldature code RAME 66020
 ISO 17672:2016 -
 EN 1044: -
 EN ISO 3677: B-Cu60MnNi -960-1030
 AWS A 5.8: -

Chemical Composition (%)

A.V.	Cu	Mn	Ni	Co	Total impurity limits (see note) Min. Max.	Other elements
	Min.	Min. Max.	Min. Max.	Min. Max.		Min. Max.
66020	rest	19 21	2 3			

NOTE Maximum impurity limits applicable to all types are (% by mass), , Cd 0,010 , Pb 0,025.

Working temperature: 1100°C
 Melting range: 960-1030°C
 Characteristics / Applications:

High-temperature brazing alloy for brazing of alloyed and unalloyed steel as well as hard metals,. The addition of Ni and Mn leads to a better wetting properties on hard metal / steel joints. This alloy is mainly used on hard metals

Heat sources:

Vacuum furnace, inert continuous furnace
 suggested Life shelf : 1 year from production s, but only in the original sealed container at storage temperatures between +5 to +30 °C. Avoid rapid changes in temperature.

Flux: -

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated Rods	Wire	Foil	Perform	Powder	Paste
					X	X