

	<h1>TECHNICAL DATA SHEET</h1>	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 68610
 ISO 17672:2016 -
 EN 1044: -
 EN ISO 3677: B-Cu86MnCo -960-1030
 AWS A 5.8: -

Chemical Composition (%)						
A.V.	Cu	Mn	Ni	Co	Total impurity limits (see note)	Other elements
	Min.	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
68610	rest	9 11	-	3 5		

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

Working temperature: 1090 °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 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