	TECHNICAL DATA SHEET	Realease	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 68710
ISO 17672:2016 -
EN 1044: -
EN ISO 3677: B-Cu87NiMn –960-1030
AWS A 5.8: -

Chemical Composition (%)						
A.V.	Cu Min.	Mn Min. Max.	Ni Min. Max.	Co Min. Max.	Total impurity limits (see note) Max.	Other elements Min. Max.
68710	rest	9 11	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

Flux: -
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.

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated Rods	Wire	Foil	Perform	Powder	Paste
					x	x