

5	0.15.60010
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 6971
ISO 17672:2016	-Cu 186
EN 1044:	CU 105
EN ISO 3677:	B-Cu97Ni(B) –1085-1100
AWS A 5.8:	-

Chemical Composition (%)								
	Cu	Sn	Ni	В	Total	Other		
					impurity	elements		
A.V.	Min.	Min.	Min.	Min.	limits			
		Max.	Max.	Max.	(see note)	Min.		
					Max.	Max.		
	rest		2,5	0,02	0,060			
RAME			3,5	0,05	Excluding			
					Ag AS Ni			

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

Working temperature:	1100°C				
Melting range:	1085-1100°C				
Specific gravity:	8,9 g/cm ³				
Characteristics / Applications:					

High-temperature brazing alloy for brazing of alloyed and unalloyed steel as well as hard metals,. The addition of nickel leads to a higher tensile strength compared to pure copper and better wetting properties on hard metal / steel joints. This alloy is mainly used on drill bits and bore-crown

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
					х	х

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