

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

Chemical Composition (%)						
A.V.	Cu	Sn	Ni	B	Total impurity limits (see note)	Other elements
	Min.	Min. Max.	Min. Max.	Min. Max.	Max.	Min. Max.
RAME	rest		2,5 3,5	0,02 0,05	0,060 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/cm³
 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
					X	X