	<b>TECHNICAL DATA SHEET</b>	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 6980  
 ISO 17672:2016 -  
 EN 1044: -  
 EN ISO 3677: B-Cu98Ni -1085-1100  
 AWS A 5.8: -

Chemical Composition ( % )						
A.V.	Cu	Sn	Ni	P	Total impurity limits (see note)	Other elements
	Min.	Min. Max.	Min. Max.	Min. Max.	Max.	Min. Max.
RAME	rest		1,5 2,5		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/cm<sup>3</sup>  
 Characteristics / Applications:

Brazing filler metal used for the joining of ferrous metals, nickel based alloy and copper nickel alloy. It is free flowing and is often used in furnace brazing, with a protective atmosphere without flux.

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
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