	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 6980 ISO 17672:2016 -EN 1044: -EN ISO 3677: B-Cu98Ni -1085-1100 AWS A 5.8: -

Chemical Composition (%)							
	Cu	Sn	Ni	Р	Total	Other	
					impurity	elements	
A.V.	Min.	Min.	Min.	Min.	limits		
		Max.	Max.	Max.	(see note)	Min.	
					Max.	Max.	
	rest		1,5		0,060		
RAME			2,5		Excluding		
					Ag AS Ni		

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

Working temperature:	1100 <i>°</i> C
Melting range:	1085-1100 <i>°</i> C
Specific gravity:	8,9 g/cm³
Characteristics / Applic	ations:

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 $^{\circ}$ C. Avoid rapid changes in temperature.

Flux: -

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated	Wire	Foil	Perform	Powder	Paste
	Rods					

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