

## TECHNICAL DATA SHEET

Realease	0 17.6.2019				
Nature	First issue				
of mod.	1/11 St 1880e				
Author	RQ				
	CPO/ST Rev.2				
Mod	del 17/06/2019				

A.V.Saldature code 9010 ISO 17672:2016 -EN 1044: -EN ISO 3677: BCu90Sn -955/1000 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.		
	balance	9,5		0,2	0,30			
9010		11,5		0,45	Excluding			
					0			

 $\mathsf{NOTE} \qquad \mathsf{Maximum\ impurity\ limit\ applicable\ to\ all\ types\ are\ (\%\ by\ mass)\ Cd\ 0,010\ and\ Pb\ 0,025}$ 

Working temperature:	1050 <i>°</i> C				
Melting range:	955/1000 <i>°</i> C				
Specific gravity:	8,9 g/cm³				
Characteristics / Applications:					

Brazing filler metal used for the joining of ferrous metals, nickel based alloy and copper nickel alloy. It is very free flowing and is often used in furnace brazing, with a protective atmosphere, generally without flux that might be necessary on metals that have constituents with difficult-to-reduce oxides, the presence of tin is useful to decrease the working temperature.

Heat sources:

Vacuum furnace, inert continuous furnace

Flux: -

## TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated Rods	Wire	Foil	Perform	Powder	Paste
		x		x	x	x

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