

	<h1>TECHNICAL DATA SHEET</h1>	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 9406
 ISO 17672:2016 CU 992
 EN 1044: Cu 201
 EN ISO 3677: B-Cu96Sn 910-1040
 AWS A 5.8:

Chemical Composition (%)								
A.V.	Cu	Sn	Ag	Ni	P	Altri	CuO2	Other elements
	Min. Max.	Min. Max.		Min. Max.	Min. Max.			Min. Max.
9406	Bal.	5,0 7,0	-	-	0,01 0,40	-	-	Al 0,005

NOTE Maximum impurity limits applicable to all types are (% by mass) Al 0,05, Cd 0,010, Pb 0,025, S 0,02, Se 0,005, Ti 0,05, Zr 0,05; if elements other than those given in this table or this note are found to be present, the amount of these elements shall be determined; the total of such other elements shall not exceed 0,50 %.

Brazing temperature: 1080°C
 Melting range: 910/1040°C

Characteristics / Applications:

Flux-free copper- tin- brazing paste with high metal content. The paste is easy to dispense and available in two different drying rates. Suitable for brazing of low-alloyed, medium-alloyed and high alloyed steel. Good wetting and flowing properties

Heat sources:

Vacuum furnace, inert continuous furnace

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated Rods	Wire	Micro Coated Rods	Oil based paste	Powder	Water based Paste
				X	X	X