

	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 9604
 ISO 17672:2016 -
 EN 1044:
 EN ISO 3677: BCu96Sn -950/1065
 AWS A 5.8:

Chemical Composition (%)						
A.V.	Cu Min.	Sn Min. Max.	Ni Min. Max.	P Min. Max.	Total impurity limits (see note) Max.	Other elements Min. Max.
9604	balance	3,0 5,0			0,30 Excluding 0	

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

Working temperature: 1070°C
 Melting range: 950/1065°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