

	<h1>TECHNICAL DATA SHEET</h1>	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 9635
 ISO 17672:2016 -
 EN 1044: -
 EN ISO 3677: B-Ni62CrPSi –1080
 AWS A 5.8: -

Chemical Composition (%)								
A.V.	NI	Cr	P	B	Fe	Cu	Si	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.				Min. Max.
9635	balance	25 27	7 8	-	Max 0,5	-	3 4	C max 0,05 Co max 0,05

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: 1100°C
 Melting range: 960/1080°C

Characteristics / Applications:

Balanced Cr content nickel brazing alloy with relevant P and Si content, this composition make this alloy suitable for those application that require wetting proprieties and corrosion resistance. 9635 brazing paste can be an alternative to 9708 (Ni5) for corrosion resistance and an alternative to 9760(Ni7) for spreading ratio

Heat sources:
 Vacuum furnace, inert continuous furnace (Ar or H₂)

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