

	<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 9655
 ISO 17672:2016 Filler metal ISO 17672-Ni 800
 EN 1044: NI 108
 EN ISO 3677: B-Ni66MnSiCu -980/1010
 AWS A 5.8: BNi-8

Chemical Composition (%)								
A.V.	NI	Cr	P	Cu	Mn	C	Si	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.			Min. Max.
9655	balance	-	- 0,02	4,0 5,0	21,5 24,5	- 0,06	6,0 8,0	

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: 980/1010 °C
 Tensile strength:

Characteristics / Applications:

The alloy 9925 is used in honeycomb brazements and on other stainless and corrosion resistance materials. Its Mn content needs special procedure since Mn oxidizes more readily than chromium, hydrogen, argon and helium atmospheres must be pure and very dry. Vacuum atmosphere must have a low pressure and a low leak rate to ensure a very low partial pressure of oxygen.

Heat sources:
 Vacuum furnace, 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