

	<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 9690
 ISO 17672:2016 -
 EN 1044: -
 EN ISO 3677: B-Ni69CrCuP -870/890
 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.
9760	balance	11 13	8,6 9,4	-	-	9 11	- 0,1	

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: 870/90 °C

Characteristics / Applications:

A variety of 9760 Ni brazing filler metal with copper to improve elasticity and strength. Suitable for stainless steel brazing process especially in automotive industry

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