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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	9708
ISO 17672:2016	Filler metal ISO 17672-Ni 650
EN 1044:	NI 105
EN ISO 3677:	B-Ni71CrSi –1080/1135
AWS A 5.8:	B-Ni5

Chemical Composition (%)								
	Ni	Cr	Р	В	Fe	Cu	Si	Other
A.V.	Min. Max.	Min. Max.	Min. Max.	Min. Max.				Min. Max.
9708	balance	18,5 19,5	- 0,02	- 0,03	- 1,5	-	8,75 10,5	

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:	1150-1204 <i>°</i> C
Melting range:	1080-1135 <i>°</i> C
Tensile strength:	676 N/mm2

Characteristics / Applications:

Boron free Ni Cr Si brazing alloy suitable for certain nuclear applications,. With its high Si contain 9708 is a good choice for narrow, deep joints or for honeycomb components. The high Cr contain is a plus for components that will endure corrosive or oxidating service conditions.

Heat sources: vacuum 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
				Х	х	Х

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