	TECHNICAL DATA SHEET	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 (%)								
A.V.	Ni Min. Max.	Cr Min. Max.	P Min. Max.	B Min. Max.	Fe	Cu	Si	Other elements 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°C
Melting range: 1080-1135°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
				x	x	x