

	<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 9733  
 ISO 17672:2016 Filler metal ISO 17672-Ni 600  
 EN 1044: -  
 EN ISO 3677: B-Ni74CrSiFeB(C) –980/1060  
 AWS A 5.8: B-Ni1

Chemical Composition ( % )								
A.V.	NI	Cr	P	B	Fe	C	Si	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
9733	balance	13 15	- 0,02	2,75 3,5	4,0 5,0	0,60 0,90	4 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: 1100 °C  
 Melting range: 980/1060 °C  
 Tensile strength: 383 N/mm<sup>2</sup>

#### Characteristics / Applications:

Ni brazing paste suitable for Ni, Cr or iron based metal. Excellent oxidation and corrosion resistance it can be used for high thermal and dynamic stressed joints such turbine blades or hot area of steel engines. To be used in vacuum and belt furnace with pure atmosphere(H<sub>2</sub> or Ar).

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