	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 9815
ISO 17672:2016 Filler metal ISO 17672-Ni 612
EN 1044: NI 109
EN ISO 3677: B-Ni81CrB –1055
AWS A 5.8: B-Ni9

Chemical Composition (%)								
A.V.	NI Min. Max.	Cr Min. Max.	P Min. Max.	B Min. Max.	Fe	Cu	Si	Other elements Min. Max.
9824	balance	13,5 16,5	-	3,25 4	- 1,5	-	-	

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: 1080°C
Melting range: 1055°C

Characteristics / Applications:

Eutectic Ni Cr B brazing alloy suited to diffusion brazing applications. Depending upon the diffusion time and temperature the join remelt temperature can be above 1371°C . Excellent oxidation and corrosion resistance. Suitable for stainless steel brazing process can be used in belt furnace (H_2 or Ar).

Heat sources:
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