

## **TECHNICAL DATA SHEET**

Realease	1 4.8.2020
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Nature of mod.	Norm update
Author	RQ
Mod	CPO/ST Rev.2 del 17/06/2019

A.V.Saldature code	9824
ISO 17672:2016	Filler metal ISO 17672-Ni 620
EN 1044:	NI 102
EN ISO 3677:	B-Ni82CrSiBFe –970/1000
AWS A 5.8:	B-Ni2
SAE	AMS4777
R-R MLC 104	MSRR 9500/97

Chemical Composition ( % )									
	NI	Cr	Р	В	Fe	Cu	Si	Other elements	
A.V.	Min.	Min.	Min.	Min.				Min.	
	Max.	Max.	Max.	Max.				Max.	
9824	balance	6	-	2,75	2,5		4		
9024		8	0,02	3,5	3,5	-	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°CMelting range:970/1000°CTensile strength:383 N/mm²

Characteristics / Applications:

Ni brazing paste largely used in automotive industry, excellent oxidation and corrosion resistance. Suitable for stainless steel brazing process can be used in vacuum and belt furnace ( $H_2$  or Ar).

Heat sources: Vacuum furnace, inert continuous furnace

suggested Life shelf : 1 year from production s, but only in the original sealed container at storage temperatures between +5 to +30 °C. Avoid rapid changes in temperature

## 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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