

	<h1>TECHNICAL DATA SHEET</h1>	Release	1 4.8.2020
		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 ( % )								
A.V.	NI	Cr	P	B	Fe	Cu	Si	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.				Min. Max.
9824	balance	6 8	- 0,02	2,75 3,5	2,5 3,5	-	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: 1080°C  
 Melting range: 970/1000°C  
 Tensile strength: 383 N/mm<sup>2</sup>

#### 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<sub>2</sub> 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
				X	X	X