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|---|-------------------------------|----------------|-----------------------------|
|  | <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 9890
 ISO 17672:2016 Filler metal ISO 17672-Ni 700
 EN 1044: NI 106
 EN ISO 3677: B-Ni89P –1055
 AWS A 5.8: B-Ni6

| Chemical Composition (%) | | | | | | | | |
|----------------------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|----------------|
| A.V. | NI | Cr | P | B | Fe | Cu | Si | Other elements |
| | Min. Max. | Min. Max. | Min. Max. | Min. Max. | Min. Max. | Min. Max. | Min. Max. | Min. Max. |
| 9890 | balance | - | 10,0 12,0 | - | - | - | - | |

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: 927-1093 °C
 Melting range: 875 °C

Characteristics / Applications:

Free flowing brazing alloy used in marginally protective atmospheres or in components that require Ni brazing at low temperature. The low erosion properties of this alloy make it a good choice for tin metal sections like those found on heat exchangers.

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 |