

	<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 9925  
 ISO 17672:2016 Filler metal ISO 17672-Ni 631  
 EN 1044: NI 104  
 EN ISO 3677: B-Ni95SiB -980/1070  
 AWS A 5.8: BNi-4

Chemical Composition ( % )								
A.V.	NI	Cr	P	B	Fe	C	Si	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.				Min. Max.
9925	balance		- 0,02	1,5 2,2	- 1,5	- 0,06	3,0 4,0	

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: 1040 °C  
 Melting range: 980/1070 °C  
 Tensile strength: 393 N/mm<sup>2</sup>

#### Characteristics / Applications:

Ni brazing paste similar to 9930 but with wider melting range that can be helpful in filling wider clearances or forming fillets. For Ni, Cr or iron based metal. Good oxidation and corrosion resistance this Cr free Ni brazing alloy can be used for honeycomb assemblies for jet engines stainless steel pipes for aircraft components. Because this alloy flows very well, it is an excellent choice for deep narrow joints. It can be used in vacuum and belt furnace with marginal protective atmosphere.

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

NiCtiOM