	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 S21
ISO 17672:2016 Filler metal ISO 17672-Cu 470a
EN 1044: CU 301
EN ISO 3677: B-Cu 60 Zn (Si) –875/895
AWS A 5.8: -

Chemical Composition (%)							
A.V.	Cu Min. Max.	Zn Min. Max.	Sn Min. Max.	Si Min. Max.	Mn	Ni	Other elements Min. Max.
S21	58,5 61,5	Rest	- 0,2	0,2/0,4			

NOTE Maximum impurity limits applicable to all types are (% by mass) Al 0,01, As 0,01, Bi 0,01, Cd 0,010, Fe 0,25, Pb 0,025, Sb 0,01; total impurities (excluding Fe) 0,2

Working temperature: 900°C
Melting range: 875/895°C
Specific gravity: 8,4 g/cm^3
Tensile strength: 350 N/mm^2
Elongation: 35%
Electrical conductivity: 15,0 m/Ω mm^2
Characteristics / Applications:

General pourpose brass alloy, suitable for gap brazing and coating of steel , cast iron, iron, nickel, nickel alloys and copper.

Heat sources:
Acetylene torch, air-gas torch, induction and resistance heating

Flux: D54, D51A, DB, DL89,DL88, DL87 AND ECOFLUX® series

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated Rods	Wire	Micro Coated Rods	spool	Powder	Paste
x	x	x	x	x		