	TECHNICAL DATA SHEET	Realease	0 17.6.2021
		Nature of mod.	First issue
		Author	RQ
		Mod	CPO/ST Rev.2 del 17/06/2019

A.V.Saldature code T 5832 M 11 XS
Filler metal ISO 17672: -
EN 1044: -
EN ISO 3677: Bag58CuSnMn 605/730
AWS A 5.8: -

Chemical Composition (%)					
A.V.	Ag Min. Max.	Cu Min. Max.	Mn Min. Max.	Sn Min. Max.	Other elements Min. Max.
T5832	56,5 58,5	31 34	2,5 3,5	6 8	

NOTE Maximum impurity limits applicable to all types are (% by mass) Al 0,001, Bi 0,030, P 0,008, Pb 0,025; total of all impurities = 0,15; total of all impurities for Ag 427, Ag 449 and Ag 485 = 0,30.

Working temperature: 750°C
Melting range: 605/730 °C
Specific gravity: -
Tensile strength: -
Elongation: -
Electrical conductivity: -
Characteristics / Applications:

Free-flowing alloy for brazing tungsten carbide. Wets some metals that are difficult to wet by more standard alloys, e.g. chromium and tungsten carbides. Does not tend to produce porous fillets despite manganese content. Excellent wetting of high manganese stainless steels in vacuum brazing. Does not outgas during titanium nitride coating.

Heat sources:
Vacuum or belt furnace

Special Binder XS is design to evaporate and glue the join before the brazing cycle (usually in vacuum furnace). 15-20 min at 100°C-125°C depending on the dimension and complexity of the join. The binder will also evaporate at room temperature in few hours

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coeted Rods	Wire	Foil	Perform	Powder	Paste
						x