

	<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            T 6426  
 Filler metal ISO 17672:       -  
 EN 1044:                        -  
 EN ISO 3677:                 BAg64CuInMnNi 730/780  
 AWS A 5.8:                      -

Chemical Composition ( % )					
A.V.	Ag	Cu	Mn	Ni	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T6426	63 65	bal	1,5 2,5	1,5 2,5	In 4 6

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.

Melting range approx. 730 - 780 °C  
 Working temperature approx. 770 °C  
 Density approx. 9.6 g/cm<sup>3</sup>  
 Shear strength acc. DIN EN 12797 150 - 300 MPa (carbide/steel)  
 Operating temp. of brazed joint max. 200 °C (without loss in strength)

#### Characteristics / Applications:

T6426 is a low melting silver based brazing alloy with copper interlayer to compensate the internal stresses of the joint. The brazing alloy is suitable for brazing of cemented carbides to steel. The reachable strength of the joint depends from the parent metals. To be used especially if parts are going to get a vacuum coating as e.g. TiN (Zn-containing brazing alloys are not suitable). It can be used for brazing with flame, with induction heating and in a furnace under protective atmospheres.

Heat sources:  
 Flame/induction heating (EN1045 FH10 in the binder)  
 furnace under protective atmospheres.

### TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

#### Availability

Rods	Coated Rods	Wire	Foil	Perform	Powder	Paste
X		X			X	X