

	<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 T6510AM11XS
 ISO 17672:2016 N.A.
 EN 1044: -
 EN ISO 3677: B-65 Ag Cu Ti 780-805
 AWS A 5.8: N.A.

Chemical Composition (%)				
A.V.	Ag	Cu	Ti	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T6510A	64,5 65,5	25 26	8 10	

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: 780-805°C
 Working temperature: 850°-950°C

Characteristics / Applications:

Active alloy. Can be used for brazing ceramics, metal-ceramics, graphite, corundum, sapphire, ruby. Needs at least 850 C for wetting ceramics, higher temperatures improve wetting. For use under argon or vacuum, in vacuum silver may evaporate above 900°C.

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	Coated Rods	Wire	Foil	Perform	Powder	Paste
						X