

	<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 6528 M 11 XS
 Filler metal ISO 17672: -
 EN 1044: -
 EN ISO 3677: BAg65Cu28Mn5Ni2 750/850
 AWS A 5.8: -

Chemical Composition (%)					
A.V.	Ag	Cu	Mn	Ni	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T6528	64 66	26 28	3,5 5,5	1 3	

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: 900°C
 Melting range: 750/850 °C
 Specific gravity: -
 Tensile strength: -
 Elongation: -
 Electrical conductivity: -
 Characteristics / Applications:

For alloys like kovar and invar to copper, for vacuum tubes. As rubbing seals in jet engines.

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	Coated Rods	Wire	Foil	Perform	Powder	Paste
						X