

	<b>TECHNICAL DATA SHEET</b>	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 T688AM11XS  
 T 688 ACTIVE-11 PASTA XS (BAg68CuTi-780/900)  
 ISO 17672:2016 N.A.  
 EN 1044: -  
 EN ISO 3677: B-Ag 68 Cu Ti 780-900  
 AWS A 5.8: N.A.

Chemical Composition ( % )					
A.V.	Ag	Cu	Ti	In	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T688A	67 69	Bal.	3 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.

Working temperature: 800-900°C  
 Melting range: 780°-900°C

#### Characteristics / Applications:

Active alloy. Can be used for brazing ceramics, metal-ceramics, graphite, diamond, 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 joint 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	X