

	<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 codes T99214M11XS
 ISO 17672:2016 Filler metal ISO 17672-AG 456a
 EN 1044: AG 403
 EN ISO 3677: B-56 Ag Cu In-600/700
 AWS A 5.8: BAg-29 BVAg-29 (vacuum grade)

Chemical Composition (%)					
A.V.	Ag	Cu	Ni	In	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T99214	55 57	26,25 28,2	2,0 2,5	13,5 15,5	

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: 600-710°C
 Specific gravity:
 Tensile strength:
 Elongation:
 Electrical conductivity:
 Characteristics / Applications:

T99214 is a special alloy that was developed to combat interfacial (crevice) corrosion which can occur when a silver brazed joint made between certain grades of stainless steel is exposed to water, water vapour or aqueous solutions in service

Heat sources: vacuum 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