	TECHNICAL DATA SHEET	Realease	0 17.6.2019
		Nature of mod.	First issue
		Author	RQ
		Mod	CPO/ST Rev.2 del 17/06/2019

A.V.Saldature code TRIMETALLICO Z
ISO 17672:2016 N.A.
EN 1044: N.A.
EN ISO 3677: B-49 Ag Cu Zn– Mn (Ni)680-705
AWS A 5.8: N.A.

Chemical Composition (%)					
A.V.	Ag Min. Max.	Cu Min. Max.	Zn Min. Max.	Mn Min. Max.	Other elements Min. Max.
TRIMETALLICO Z	49	27,5	20,5	2,5	Ni 0,5

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: 690°C
Melting range: 680°-705°C
Specific gravity: 9 g/cm^3
Shear strength: 150 - 300 N/mm^2
elongation: 35%

Characteristics / Applications:
Cu and silver alloy foils for joints of hard metals and carrier steel. The foil is usually devided as 1:2:1 dimentions with silver alloy on the outstanding side. The Cu does not melt during the brazing process.

Heat sources:
Acetylene torch, induction and resistance heating

Flux: D26, D26 PASTE or DKBLACK PASTE

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coeted Rods	Wire	Foil	Perform	Powder	Paste
			x			