

	<h1>TECHNICAL DATA SHEET</h1>	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 AU702  
 ISO 17672:2016 Filler metal ISO 17672-Au 700  
 EN 1044: AU 106 (AU 106V for vacuum grade)  
 EN ISO 3677: B-70 AuNiPd-1005/1045  
 AWS A 5.8: BAu-6

<b>Chemical Composition ( % )</b>					
A.V.	Au	Cu	Pd	Ni	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
AU702	69,5 70,5	-	7,5 8,5	21,5 22,5	

NOTE Impurity limits for AU105 (%by mass, max.): - Al 0.0010, P 0.008, Ti 0.002, Zr 0.002 total of all impurities 0.15%. Impurity limits for AU105V Grade 1 (%by mass, max.): - C 0.0005, Cd 0.001, P 0.002, Pb 0.002, Zn 0.001, Mn 0.001, In 0.002, all other elements where vapour pressure at 500°C is  $>1.3 \times 10^{-10}$  bar 0.001 each, limited to 0.010% total (inc. Cd, Pb and Zn)

Working temperature: 1050 °C  
 Melting range: 1005-1045 °C  
 Specific gravity:  
 Tensile strength:  
 Elongation:

### Characteristics / Applications:

Gold brazing alloy filler metal used for the brazing of iron, nickel and cobalt base metals. Great resistance to oxidation, corrosion. Great ductility that can play an important role in the service of the part. Commonly used on thin base metals due to its low rate of interaction with base metals. To be used in elevated temperatures service conditions

### Heat sources:

Induction, resistance heating, protective atmosphere furnace, vacuum furnace

Flux: MX20/M20/M16 EN1045 FH21 in the binder  
 MX30/M30 EN1045 FH10 in the binder  
 M11 no flux

## TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

### Availability

Rods	Coated Rods	Wire	Foil	Perform	Powder	Paste
					X	X