

	<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 AU821
 ISO 17672:2016 Filler metal ISO 17672-Au 827
 EN 1044: AU 105 (AU 105V for vacuum grade)
 EN ISO 3677: B-82 AuNi-950
 AWS A 5.8: BAu-4

Chemical Composition (%)					
A.V.	Au	Cu	Pd	Ni	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
AU821	81,5 82,5	-	-	17,5 18,5	

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 >1.3x10⁻¹⁰ bar 0.001 each, limited to 0.010% total (inc. Cd, Pb and Zn)

Working temperature: 950°C
 Melting range: 950 °C
 Specific gravity:
 Tensile strength: 792 MPa
 Elongation: 14%

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

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
	-	F/B	N	PL/A	P	M