

	<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 T68
 ISO 17672:2016 -
 EN 1044: AG 206
 EN ISO 3677: B-44 Cu Zn Ag -690/810
 AWS A 5.8: -

Chemical Composition (%)					
A.V.	Ag	Cu	Zn	Sn	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T68	19 21	43 45	34 38		Si 0,05 0,25

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: 810 °C
 Melting range: 690/810 °C
 Specific gravity: 8,7 g/cm³
 Tensile strength: 380/450 N/mm²
 Elongation: 25%
 Electrical conductivity: 10,6 m/Ω mm²
 Characteristics / Applications:

Cd-free silver brazing alloy . For brazing brass, steel, cast iron, copper, copper alloys, nickel alloys. It has very good resistance to overheating and high tensile strength. Perfect match with brass color.

Heat sources:
 Acetylene torch, air-gas torch, induction and resistance heating

Flux: D4, D26, D60, D70, D39H

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated Rods	Wire	Foil	Perform	Powder	Paste
X	X	X		X		