

VBC Alloy 4770 Microbraz 50

Designation	Microbraz 50		Issued: April/14	MSRR: N/A	AWS: BNi-7
			Revision: 00		
Cross Reference/ Conformance Specifications	BS EN 1044 Ni107 AWS A5.8 BNi-7 BS EN ISO 17672:2010 Ni 710		UNS Number N99710 ISO 3677 B-Ni76CrP-890 JIS BNi-7		
Description	Nickel base alloy for honeycomb brazing and thin walled structures				
Temperatures	Solidus: 890°C	Liquidus: 890°C	Brazing Range: 925 - 1095°C		
Materials To Be Brazed, Applications and Advice	Honeycomb structures, thin-walled tube assemblies, carbide, diamond Nuclear applications due to boron free alloy. Good high temperature and corrosion properties. High strength joint. Free flowing alloy. Nickel plate Inconel X or A286 Gap Size: 0.001" /0.025mm.				
Chemical Composition WT%	Chromium – 13.0-15.0%		Sulphur – 0.02% max		
	Boron – 0.01% max		Aluminium – 0.05% max		
	Silicon – 0.10% max		Titanium – 0.05% max		
	Iron – 0.2% max		Manganese – 0.04% max		
	Carbon – 0.08% max		Zirconium – 0.05% max		
	Phosphorous - 9.7-10.5%		Nickel – Balance		
Physical Properties	Brazing Range – 925 - 1095°C				
Forms of Supply	Tape Powder Paste				

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