

VBC Alloy 4776M Nicrobraz LC

Designation	Nicrobraz LC		Issued: August/14	MSRR: N/A	AMS: 4776H
			Revision: 00		
Cross Reference/ Conformance Specifications	AMS 4776H BS EN 1044 NI1A1 AWS A5.8 BNi-1a PWA 996	BS EN ISO 17672:2010 Ni 610 UNS Number N99610 ISO 3677 B-Ni74CrFeSiB-980/1070 JIS BNi-1A			
Description	Nickel based braze alloy (Low carbon)				
Temperatures	Solidus: 980°C	Liquidus: 1075°C	Brazing Range: 1065 - 1205°C Recommended: 1175°C		
Materials To Be Brazed, Applications and Advice	Used for Stainless steel assemblies which are subjected to severe service conditions. Also steel and nickel alloys. High strength alloy for use on jet engine diffusers ad honeycomb applications. More sluggish than the similar BNi-1(VBC Alloy 4775) at brazing temperature. Suitable for wide gap applications. Recommended gap size: 0.002" – 0.015" (0.05mm – 0.38mm)				
Chemical Composition WT%	Carbon – 0.06% max	Cobalt – 0.10% max			
	Silicon – 4.0 – 5.0%	Titanium – 0.05% max			
	Phosphorous – 0.02% max	Aluminium – 0.05 %max			
	Sulphur – 0.02% max	Selenium – 0.005% max			
	Chromium – 13.0 – 15.0%	Zirconuim – 0.05% max			
	Boron – 2.75 – 3.5%	Nickel – Balance			
	Iron – 4.0 – 5.0%				
Physical Properties	Density	7.75 g/cm ³ (Mg/m ³)			
Forms of Supply	Powder Paste Foil Tape				

Disclaimer: All information regarding our products is based on applied experience and extensive research work. We provide these technical data in good faith that they are accurate; this does not exempt the user from the obligation to check the information contained herein, especially if the application and process has not been expressly approved by us in writing. Any changes to processes must be approved by your organisations own quality department. VBC cannot be held responsible for any errors, omissions or inaccuracies published.