

VBC Alloy 4779 Nicrobraz 135/Amdry 790

Designation	Nicrobraz 135/Amdry 790		Issued: May /15	MSRR: 9500/700	AWS:BNi-4
			Revision: 00		
Cross Reference/ Conformance Specifications	AMS 4779G BS EN 1044 Ni104 AWS A5.8 BNi-4 MSRR 9500/700 General Electric B50TF206		BS EN ISO 17672:2010 Ni 631 UNS Number N99640 ISO 3677 B-Ni95SiB-980/1070 JIS BNi-4 Omat 3/88 - 3/88B - 3/88C - 3/88E		
Description	Nickel based braze alloy				
Temperatures	Solidus: 982°C		Liquidus: 1066°C		Brazing Range: 1065-1175°C
Materials To Be Brazed, Applications and Advice	Steel, Stainless steel and Nickel based Superalloys for aerospace components and food handling equipment. Also good for honeycomb and other thin section parts. Useful when the braze joint needs to be machined post brazing. Wide melting range which helps when wide gaps are brazed. Excellent ductility, good strength and corrosion resistance. Rebraze temperature will be higher as melting point depressants Si and B diffuse into the base material. Recommended atmosphere: Vacuum (preferred), Argon, Pure dry Hydrogen Recommended Gap size: - 0.05mm – 0.3mm (0.002”-0.012”)				
Chemical Composition WT%	Carbon – 0.06% max		Iron – 1.5% max		
	Silicon – 3.0 – 4.0%		Cobalt – 0.1% max		
	Phosphorous – 0.02% max		Titanium – 0.05% max		
	Sulphur – 0.02% max		Aluminium – 0.05% max		
	Boron – 1.5 – 2.2%		Selenium – 0.005% max		
	Zirconium – 0.05% max		Nickel – Balance		
Physical Properties	Density	7.65 g/cm ³			
	Viscosity	Medium			
Forms of Supply	Wire Foil Powder Paste Preforms Tape				

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