

Brazing - Filler metals

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NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 17672:2010 sisaldab Euroopa standardi EN ISO 17672:2010 ingliskeelset teksti.

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English Version

Brazing - Filler metals (ISO 17672:2010)

Brasage fort - Métaux d'apport (ISO 17672:2010)

Hartlöten - Lote (ISO 17672:2010)

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EUROPEAN COMMITTEE FOR STANDARDIZATION
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Foreword

This document (EN ISO 17672:2010) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding" the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by December 2010, and conflicting national standards shall be withdrawn at the latest by December 2010.

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Endorsement notice

The text of ISO 17672:2010 has been approved by CEN as a EN ISO 17672:2010 without any modification.

Contents

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Composition	1
4 Special vacuum requirement	2
5 Chemical analysis	2
6 Designation	3
7 Technical delivery conditions	3
7.1 Types of product	3
7.2 Dimensions	3
7.3 Condition	5
7.4 Marking	5
7.5 Packaging	5
7.6 Product certificates	5
8 Metal hazards	5
Annex A (normative) Codification	16
Bibliography	22

Brazing — Filler metals

1 Scope

This International Standard specifies the compositional ranges of a series of filler metals used for brazing. The filler metals are divided into seven classes, related to their composition, but not necessarily to the major element present.

NOTE 1 For the major element(s) present, see Annex A.

In the case of composite products, such as flux-coated rods, pastes or plastics tapes, this International Standard covers only the filler metal that forms part of such products. The melting temperatures given in the tables are only approximate, as they necessarily vary within the compositional range of the filler metal. Therefore, they are given only for information. Technical delivery conditions are given for brazing filler metals and products containing brazing filler metals with other constituents such as flux and/or binders.

NOTE 2 For some applications, e.g. precious metal jewellery, aerospace and dental, filler metals other than those included in this International Standard are often used and these are covered by other International Standards to which reference can be made.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3677:1992, *Filler metal for soft soldering, brazing and braze welding — Designation*

ISO 80000-1:2009, *Quantities and units — Part 1: General*

3 Composition

The filler metal shall have a composition in accordance with Tables 5 to 13 for the particular type, except as modified for special vacuum requirements (see Clause 4 and Table 1).

For the purposes of determining compliance with composition limits, any value obtained from the analysis shall be rounded to the same number of decimal places as used in this International Standard in expressing the specified limit. The following rules shall be used for rounding.

- a) When the figure immediately after the last figure to be retained is less than five, then the last figure to be retained shall be kept unchanged.
- b) When the figure immediately after the last figure to be retained is either
 - 1) greater than five, or
 - 2) equal to five and followed by at least one figure other than zero,the last figure to be retained shall be increased by one.