
Brazing — Filler metals

Brasage fort — Métaux d'apport



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 17672 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*.

Requests for official interpretations of any aspect of this International Standard should be directed to the Secretariat of ISO/TC 44/WG 3 via your national standards body, a complete listing which can be found at <http://www.iso.org/>.

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.