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**Filler metal for soldering and  
brazing — Designation**

*Métaux d'apport de brasage tendre et de brasage fort — Désignation*



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## Foreword

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The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 13, *Brazing materials and processes*.

This third edition cancels and replaces the second edition (ISO 3677:1992), which has been technically revised.

# Filler metal for soldering and brazing — Designation

## 1 Scope

This International Standard specifies designations for filler materials for soldering and brazing, on the basis of their chemical composition. For brazing materials only, the designation includes their solidus/liquidus temperatures. This International Standard deals with the metallic part of filler materials used in soldering and brazing products, e.g. foils, wires, rods, pastes, flux coated rods/wires, flux cored rods/wires, etc.

## 2 Symbols and requirements

### 2.1 General

The designation is divided into two parts for soldering filler metals and three parts for brazing filler metals. In each case, the parts are separated by a dash.

### 2.2 First part (applicable to all materials)

The first part consists of a letter denoting the type of use of the material, as follows:

- a) “S” shall be used for all soldering filler metals;
- b) “B” shall be used for all brazing filler metals.

NOTE For solders for electronic applications, see also [2.3.6](#).

### 2.3 Second part (applicable to all materials)

**2.3.1** The second part consists of a group of symbols, in accordance with the classification given in [2.3.2](#) to [2.3.6](#), indicating the various metals or metalloids making up the filler metal.

**2.3.2** The chemical symbol of the major element in the filler metal is placed first. This is followed by the nominal mass percentage of the element concerned. This value shall be expressed as a whole number with an accuracy of  $\pm 1$ .

When a range is specified for an element in the alloy, the nominal value to be used in the designation should be the mean of the range, rounded to the nearest whole number, or rounded to the nearest even number if the mean is halfway between two whole numbers. When only a minimum value is specified, however, the rounded-off minimum percentage should be used as the nominal value in the designation.

**2.3.3** The chemical symbols of the other metals or metalloids specified in the alloy are given in decreasing order of their nominal percentage. In addition, for soldering filler metals only, each chemical symbol shall be followed by the nominal mass percentage of the element concerned (see [2.3.2](#)). If two or more elements have the same nominal mass percentage they shall be classified in order of decreasing atomic number.

**2.3.4** Metals or metalloids with a nominal specified value (see [2.3.2](#)) less than 1 % by mass shall not be indicated in the designation, unless these elements are functional components of the alloy; in which case, they shall be indicated by:

- a) for soldering filler metals, their chemical symbols only;