

## Material Specifications for Ni-Base Brazing Powder

(01) Material Grade: No-600 (Chinese Specification)

*Quantity : 15 kg*

(02) Chemical Composition (wt %):

Cr	Si	Fe	Pd	P	Ge	B	Co
16.5~17.5	9.5~10.5	8.5~9.5	4.5~5.0	1.5~1.8	2~3	≤0.001	≤0.1
O <sub>2</sub>	As+Br+Sb+Sn+Pb				Ni		
<0.05	<0.2				Rest		

(03) Technical Requirements:

- Grain Size  $\leq 120 \mu\text{m}$
- Melting Temperature = 1050~1070 °C
- Total Rupture Strength at brazed joint
  - At Room Temperature  $\geq 4900 \text{ N}$
  - At 350 °C  $> 295 \text{ MPa}$
- During metallographic examination of brazed joint intergranular penetration should be  $\leq 0.035 \text{ mm}$

(04) Packing Requirements:

Brazing powder should be packed in a container having vacuum  $\leq 1.33 \text{ MPa}$ . It should be free from moisture. The container should be clearly marked as:

- Name of the powder
- Furnace number
- Specifications
- Quantity
- Name of the manufacturer
- Packing date
- Mark of moisture proof

(05) Sample Qualification

*A sample must be provided to the end user by supplier for necessary qualification at end user premises. Quotations may show shipment charges for the sample separately.*