



NiCrBSi 1000 + 8% Ni

Classification		Nickel Based Alloy	Issued July 2019 Revision 1.0		
AMS: 4777 (92% by weight)	AWS: BNi-2 (92% by weight)	MSRR:	General Electric: B50TF17 – (8% by weight) B50TF204 – (92% by weight)	Snecma DMR35:	
Recommended Brazing Atmospheres		Vacuum Hydrogen Inert Gases			
Applications		Low melting point, corrosion and oxidation resistant filler metal with good elevated temperature strength. Addition of 8% nickel to enhance wide-gap capabilities. Nickel will not melt within brazing range.			
Melting Range 4777		Solidus: 971C	Liquidus: 999C	Brazing Range: 1040-1175C	
Melting Range Nickel		Solidus: 1393C	Liquidus: 1427C		
Nominal Composition 4777 (92%)		Si – 4.1	Cr – 7.0	Ni - Balance	Fe- 3.0 B – 3.0
Additives		8% by volume added Nickel (99% purity)			
Forms of Supply		Powder			
Mesh		AMS4777 powder is -140 (92%) B50TF17 is -325 (8%)			
Braze Alloy Colour Code		Product labels are marked with the colour along the edge of the label		N/A	
Storage Recommendations		<ul style="list-style-type: none"> • Powder should be stored in the original closed container in a dry location. Powder should be mixed thoroughly before use to ensure a uniform distribution of the two mesh sizes. • Paste should be stored tip down in the original packaging. • Tapes, ropes and foils should be stored in their sealed bags to minimise drying. 			
Safety Recommendation		Please refer to the specific MSDS (Material Safety Data Sheet) – available from Vitta			
Disclaimer		All information provided on our products is based upon our experience and extensive testing and research. Information on these technical data sheets is provided in good faith but does not exempt the user from the requirement to check the data held herein. It is the responsibility of the customer to ensure that the product is suitable for the intended use particularly if the application or process has not been specifically approved by us in writing. Vitta cannot be held liable for any errors or omissions published. Vitta always recommend your internal quality team must approve any proposed usage.			