



Vitta-Braze 1777

Classification		Nickel Based Alloy	Issued July 2019 Revision 1.0			
AMS: 4777	AWS: BNi-2	MSRR: 9500/97	General Electric: B50TF204	Pratt & Whitney:	Snecma DMR35: -302	
Cross Reference / Conformance		Allied Signal EMS 54752: Type II Wall Colmonoy (Nicrobraze): LM	Praxair Alloy: Ni-362 Metco (Amdry): 770			
Recommended Brazing Atmospheres		Vacuum Hydrogen Inert Gases				
Applications		Low melting point, corrosion and oxidation resistant filler metal with good elevated temperature strength. Suited for joining non-ferrous alloys, steels and thin sections such as heat exchangers and honeycomb components. Used also for coatings.				
Melting Range		Solidus: 971C	Liquidus: 999C	Brazing Range: 1010-1175C		
Nominal Composition		Si – 4.1	Cr – 7.0	Ni - Balance	Fe- 3.0	B – 3.0
Forms of Supply		Powder, Tape, Rope, Paste, Preforms, Foil				
Mesh		Powder supplied to -140 as standard, please state if coarse (-140C) is required for pepper potting. Other mesh sizes available upon request.				
Braze Alloy Colour Code		Product labels are marked with the colour along the edge of the label			BROWN	
Storage Recommendations		<ul style="list-style-type: none"> • Powder should be stored in the original closed container in a dry location. If stored for a duration of time tumble contents prior to use to prevent segregation. • 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.				