



Vitta-Braze 1778

Classification		Nickel Based Alloy	Issued July 2019 Revision 1.0		
AMS: 4778	AWS: BNi3	MSRR: 9500/114	General Electric: B50TF205	Pratt & Whitney:	Snecma DMR35: -304
Cross Reference / Conformance		Allied Signal EMS 54752: Type I Wall Colmonoy (Microbraze): 130	Praxair Alloy: Ni-298 Metco (Amdry): 780		
Recommended Brazing Atmospheres		Vacuum Inert Gases Hydrogen			
Applications		Free flowing, corrosion and oxidation resistant filler metal. This filler metal wets well so it is suited for applications where deep recesses and tight clearances are encountered. Used also for coatings.			
Melting Range		Solidus: 982C	Liquidus: 1037C	Brazing Range: 1010-1175C	
Nominal Composition		Silicon – 4.5	Boron – 2.9	Nickel - Balance	
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		YELLOW	
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.			