

AEROSPACE MATERIAL SPECIFICATIONS

AMS 4780

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc. 485 Lexington Ave., New York 17, N.Y.

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Revised

BRAZING ALLOY Manganese Base - 16Ni - 16Co - 0.8B

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. FORM: Powder.
3. APPLICATION: Primarily for joining corrosion and heat resistant alloys where good ductility and moderate heat resistance are required.
4. COMPOSITION:

Carbon	0.06	max
Silicon	1.00	max
Nickel	14.0	18.0
Cobalt	14.0	18.0
Boron	0.5	1.1
Total other elements	1.0	max
Manganese		remainder

Note. For the above composition, the following approximate values are listed for reference:

Solidus	1770 F (966 C)
Liquidus	1875 F (1024 C)

5. CONDITION: Unless otherwise specified, material shall be furnished as fabricated.
6. QUALITY: Material shall be uniform in color, quality, and condition, and free from foreign materials and from imperfections detrimental to its working qualities.
7. TOLERANCES: Powder shall be of such fineness that none of the material will be retained on a No. 120 screen and not less than 90% will pass through a No. 150 screen.
8. REPORTS: Unless otherwise specified, the vendor of the product shall furnish with each shipment three copies of a report stating that the product conforms to the requirements specified. This report shall include the purchase order number, material specification number, and quantity.

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