



**SLOVENSKI STANDARD**  
**oSIST prEN ISO 3677:2023**  
**01-oktober-2023**

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**Dodajni materiali za trdo spajkanje - Označevanje (ISO/DIS 3677:2023)**

Filler metal for brazing - Designation (ISO/DIS 3677:2023)

Zusätze zum Hartlöten - Bezeichnung (ISO/DIS 3677:2023)

Métaux d'apport de brasage fort - Désignation (ISO/DIS 3677:2023)

**Ta slovenski standard je istoveten z: prEN ISO 3677**

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**ICS:**

25.160.50      Trdo in mehko lotanje      Brazing and soldering

**oSIST prEN ISO 3677:2023**

**en,fr,de**



# DRAFT INTERNATIONAL STANDARD

## ISO/DIS 3677

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## Filler metal for brazing - Designation

*Métaux d'apport de brasage tendre et de brasage fort — Désignation*

ICS: 25.160.50

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# Contents

	Page
<b>Foreword</b> .....	<b>iv</b>
<b>1 Scope</b> .....	<b>1</b>
<b>2 Symbols and requirements</b> .....	<b>1</b>
2.1 General.....	1
2.2 First part.....	1
2.3 Second part.....	1
2.4 Third part.....	1
<b>3 Examples</b> .....	<b>2</b>

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[oSIST prEN ISO 3677:2023](https://standards.iteh.ai/catalog/standards/sist/a1657503-d273-4e0c-8bb8-839a12c359db/osist-pren-iso-3677-2023)

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## ISO/DIS 3677:2023(E)

### Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html)

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 13, *Brazing materials and processes*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 3677:2016), which has been technically revised.

The main changes are as follows:

Since soldering is covered by ISO/TC 44/SC 12, *Soldering materials*, and the corresponding designations in ISO 9453, all soldering designations were deleted from this document.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html). Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

# Filler metal for brazing - Designation

## 1 Scope

This document specifies designations for filler materials for brazing, on the basis of their chemical composition. The designation includes their solidus/liquidus temperatures. This International Standard deals with the metallic part of filler materials used in brazing products, e.g. foils, wires, rods, pastes, flux coated rods/wires, flux cored rods/wires, etc.

## 2 Symbols and requirements

### 2.1 General

The designation is divided into three parts. In each case, the parts are separated by a dash.

### 2.2 First part

The first part shall consist of the letter "B".

### 2.3 Second part

**2.3.1** The second part consists of a group of symbols, in accordance with the classification given in [2.3.2](#) to 2.3.6, indicating the various metals or metalloids making up the filler metal.

**2.3.2** The chemical symbol of the major element in the filler metal is placed first. This is followed by the nominal mass percentage of the element concerned. This value shall be expressed as a whole number with an accuracy of  $\pm 1$ .

When a range is specified for an element in the alloy, the nominal value to be used in the designation should be the mean of the range, rounded to the nearest whole number, or rounded to the nearest even number if the mean is halfway between two whole numbers. When only a minimum value is specified, however, the rounded-off minimum percentage should be used as the nominal value in the designation.

**2.3.3** The chemical symbols of the other metals or metalloids specified in the alloy are given in decreasing order of their nominal percentage. If two or more elements have the same nominal mass percentage they shall be classified in order of decreasing atomic number.

**2.3.4** Metals or metalloids with a nominal specified value (see [2.3.2](#)) less than 1 % by mass shall not be indicated in the designation, unless these elements are functional components of the alloy; in which case, they shall be indicated by their chemical symbols enclosed in parentheses.

**2.3.5** Only the chemical symbols of the first six constituents shall be indicated.

### 2.4 Third part

The third part indicates the temperatures, expressed in degrees Celsius, at the beginning and end of solidification. The solidus temperature shall be placed first, followed by the liquidus temperature. The temperatures shall be separated by an oblique stroke (slash).