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Aerospace series - Metallic materials, Filler metal for brazing - Technical specification

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

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English Version

Aerospace series - Metallic materials, Filler metal for brazing - Technical specification

Série aérospatiale - Matériaux métalliques, Métaux d'apport de brasage - Spécification technique

Luft- und Raumfahrt - Metallische Werkstoffe - Hartlote - Technische Lieferbedingungen

This European Standard was approved by CEN on 14 November 2016.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

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European foreword

This document (EN 3875:2017) has been prepared by the Aerospace and Defence Industries Association of Europe - Standardization (ASD-STAN).

After enquiries and votes carried out in accordance with the rules of this Association, this Standard has received the approval of the National Associations and the Official Services of the member countries of ASD, prior to its presentation to CEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by February 2018, and conflicting national standards shall be withdrawn at the latest by February 2018.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

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Introduction

This European Standard is part of the series of EN metallic material standards for aerospace applications. The general organization of this series is described in EN 4258.

1 Scope

This European Standard defines the requirements for the ordering, manufacture, testing, and delivery of all forms of filler metal for brazing for aerospace applications. It shall be applied when referred to in the EN material standard unless otherwise specified on the drawing, order or testing schedule.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 2032-1, *Aerospace series — Metallic materials — Part 1: Conventional designation*

EN 2032-2, *Aerospace series — Metallic materials — Part 2: Coding of metallurgical condition in delivery condition*

EN 2078, *Aerospace series — Metallic materials — Manufacturing schedule, inspection schedule, inspection and test report — Definition, general principles, preparation and approval*

EN 3876, *Aerospace series — Test method for metallic materials — Braze alloys – Fusion test*[1)]

EN 3877, *Aerospace series — Metallic materials — Test method — Determination of solidus and liquidus temperatures by differential thermal analysis of braze alloys*[1)]

EN 3878, *Aerospace series — Test method for metallic materials — Braze alloys — Flexibility test*[1)]

EN 4061, *Aerospace series — Amorphous foil in filler metal for brazing — Thickness 25 µm ≤ a ≤ 64 µm — Dimensions*[1)]

EN 4062, *Aerospace series — Rolled foil in filler metal for brazing — Thickness a ≤ 1 mm — Dimensions*[1)]

EN 4063, *Aerospace series — Wire in filler metal for brazing — Diameter 0,6 mm ≤ D ≤ 4 mm — Dimensions*[1)]

EN 4064, *Aerospace series — Tape in filler metal for brazing — Thickness 0,075 mm ≤ a ≤ 1,5 mm — Dimensions*[1)]

EN 4066, *Aerospace series — Borided foil in filler metal for brazing — Thickness 25 µm ≤ a ≤ 100 µm — Dimensions*[1)]

EN 4258, *Aerospace series — Metallic materials — General organization of standardization — Links between types of EN standards and their use*

EN 4259, *Aerospace series — Metallic materials — Definition of general terms*[1)]

EN 4268, *Aerospace series — Metallic materials — Heat treatment facilities — General requirements*

EN 9100, *Quality Management Systems — Requirements for Aviation, Space and Defence Organizations*

EN 9133, *Aerospace series — Quality management systems — Qualification procedure for aerospace standard parts*

ISO 3954, *Powders for powder metallurgical purposes — Sampling*

ISO 4497, *Metallic powders — Determination of particle size by dry sieving*

1) Published as AECMA Prestandard at the date of publication of this European Standard