

Data Sheet

Palniro[®] I (AMS 4784)

Description:

High-purity gold, nickel and palladium alloy for vacuum brazing.
Nominal composition by weight: **50% Au, 25% Ni and 25% Pd**

Prime features:

- High ductility
- High strength
- Recommended for brazing super alloys and stainless steels
- Similar to Palniro 4 but lower brazing temperature.

Typical applications:

- Aero-engines (OEM and repair)
- Aerospace fuel-line assemblies
- Vacuum tubes
- Wave guide and Klystron assemblies
- Power supply surge arrestors

Physical Properties*

Liquidus Temperature	1121 °C 2050 °F
Solidus Temperature	1102 °C 2016 °F
Coefficient of Thermal Expansion (CTE)	16.0 x 10 ⁻⁶ /C, for 20 – 1000 °C 7.8 x 10 ⁻⁶ /°F, for 68 – 1832 °F
Thermal Conductivity (Calculated)	
Density	13.1 Mg/m ³ 0.473 lb/in ³
Yield Strength (0.2% offset)	723 MPa 105 x 10 ³ lb/in ²
Tensile Strength	841 MPa 122 x 10 ³ lb/in ²
Elongation (2in/50mm gage section)	24%
Electrical Resistivity	226 x 10 ⁻⁹ ohm·m
Electrical Conductivity	XXX x 10 ⁶ /ohm·m
Vapor Pressure (Calculated)	3 x 10 ⁻⁶ mm Hg @ 1000 °C, 1832 °F 3 x 10 ⁻⁵ mm Hg @ 1100 °C, 2012 °F
Recommended Brazing Temperatures	
Recommended Brazing Atmospheres	10 ⁻⁵ mm Hg, inert gas

* Please note that all values quoted are based on test pieces and may vary according to component design. These values are not guaranteed in any way and should only be treated as indicative values. They should be used for guidance only and for no other purpose whatsoever.

Impurity Limits

Zn	less than 0.001%
Cd	less than 0.001%
Pb	less than 0.002%
P	less than 0.002%
C	less than 0.01%

All other metallic impurities having a vapor pressure higher than 10⁻⁷ mm Hg at 500 °C are limited to 0.002% each. Impurities having a vapor pressure lower than 10⁻⁷ mm Hg at 500 °C are limited to a total of 0.075%. (This applies to all forms except powder and extrudable paste.)

Supplied as:

- Foil
- Flexibraz
- Wire
- Powder
- Extrudable paste
- Preforms

The determination as to the adaptability of any Wesgo materials to the specific needs of the Buyer is solely the Buyer's prerogative and responsibility. All technical information, data and recommendations are based on tests and accumulated experience data, which Wesgo believed to be reliable. However, the accuracy and completeness thereof are not guaranteed.

