

JAPANESE
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STANDARD

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JIS Z 3191 : 2003

**Method of wetting test for
brazing filler metals**

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98

Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee in accordance with the Industrial Standardization Law. Consequently **JIS Z 3191 : 1963** is replaced with **JIS Z 3191 : 2003**.

In this revision, **ISO 5179 : 1983** *Investigation of brazeability using a varying gap test piece* is adopted as the basis for the purposes of making easy to compare this Standard with International Standard; to prepare Japanese Industrial Standard conforming with International Standard; and to propose a draft of International Standard which is based on Japanese Industrial Standard.

Date of Establishment: 1963-03-01

Date of Revision: 2003-01-20

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Investigated by: Japanese Industrial Standards Committee
Standards Board
Technical Committee on Welding

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In the event of any doubts arising as to the contents,
the original JIS is to be the final authority.

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Contents

	Page
Introduction	1
1 Scope	1
2 Normative references	1
3 Definitions	1
4 Test pieces	1
5 Testing metal	4
5.1 Base metal	4
5.2 Brazing filler metal	4
5.3 Flux and atmosphere	4
6 Heating apparatus.....	4
7 Testing method	6
7.1 Spreading test	6
7.2 Gap wettability test	6
8 Record of test results	7
8.1 Spreading test	7
8.2 Gap wettability test	7
Annex 1 (informative) Comparison table between JIS and corresponding International Standard	10

Method of wetting test for brazing filler metals

Introduction This Japanese Industrial Standard has been prepared based on **ISO 5179 : 1983** *Investigation of brazeability using a varying gap test piece* published in 1983 as the first edition, with some modification in the technical contents.

The portions with continuous sidelines or dotted underlines in this Standard are the matters modified from the original International Standard. A comparison table with its explanation is added as Annex 1 (informative).

1 Scope This Standard specifies the methods of spreading test and gap wettability test to examine the wetting condition of brazing filler metals.

Remarks : The International Standard corresponding to this Standard is as follows.

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21**.

ISO 5179 : 1983 *Investigation of brazeability using a varying gap test piece* (MOD)

2 Normative references The following standards contain provisions which, through reference in this Standard, constitute provisions of this Standard. The normative references apply limiting only to the most recent edition (including amendments).

JIS G 3101 *Rolled steels for general structure*

JIS G 4304 *Hot rolled stainless steel plates, sheets and strip*

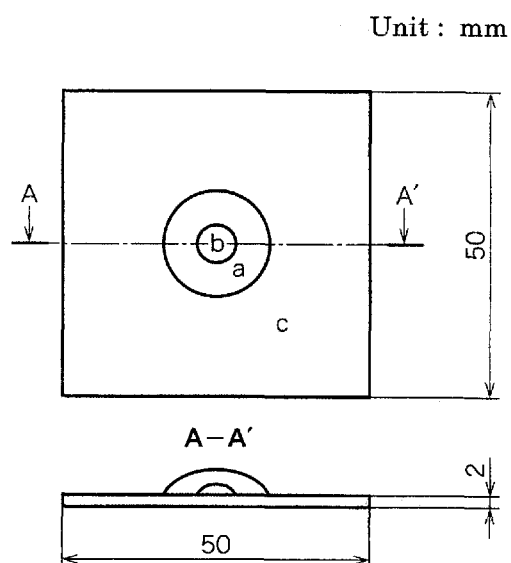
JIS H 3100 *Copper and copper alloy sheets, plates and strips*

JIS Z 3001 *Welding terms*

3 Definitions For the purpose of this Standard, the definitions in **JIS Z 3001** apply.

4 Test pieces The test piece shall have the shape and dimensions complying with Fig. 1 for spreading test, and Fig. 2 for gap wettability test.

Furthermore, the assembly of gap wettability test piece shall be as shown in Fig. 3.



- a : Flux
b : Brazing filler metal
c : Base metal

Fig. 1 The shape and dimensions of spreading test piece