Technical Data Sheet BrazeTec D 897.1

Standard
ISO 17672            Ni 710
(US-Standard ANSI/AWS A5.8) (BNi-7)
(DIN EN 1044)         (NI 107)

Nominal composition [wt.-%]
Ni Rem.; Cr 14.0; P 10.1
Permitted impurities max. [wt.-%]
Al 0.05; Co 0.10; S 0.02; Se 0.005; Ti 0.05; Zr 0.05
Si 0.10; B 0.02; Fe 0.2; C 0.06; Mn 0.04
max. impurities [wt.-%] 0.50

Technical data
Melting range of brazing alloy approx. 890 °C
Optimum brazing temperature approx. 980 °C
Density of brazing alloy approx. 7.9 g/cm³
Density of brazing paste approx. 3.9 g/cm³ (20 °C)
Metal content approx. 85 wt.-%
Grain size of brazing alloy powder < 106 µm
Viscosity 450 - 650 dPas (Haake Viscotester 02; Sp. 2; 20 ±2°C)
Cleaning agent Water
Shelf life 6 months in the original closed container storage
           temperature +5 to +30 °C
           stir well before use

Packaging
Standard 1.25; 3; 5; 10; 25 kg

Applications
BrazeTec D 897.1 is a homogenous mixture of finely dispersed brazing powder in a water based binder system.
This dosable paste can be applied by air pressure or screw dispenser techniques.
The nickel based brazing alloy can be used for brazing copper and copper alloys, nickel and nickel alloys, cobalt and cobalt alloys, any steels and stainless steel, and in some cases for special metals and their alloys.
The brazing process has to be carried out in vacuum or protective atmosphere.

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