**Technical Data Sheet BrazeTec D 1002.1**

**Standard**
- ISO 17672
- (US-Standard ANSI/AWS A5.8)
- (DIN EN 1044)

**Nominal composition [wt.-%]**
- Ni Rem.; Cr 7.0; Si 4.5; B 3.1; Fe 3.0

**Permitted impurities max. [wt.-%]**
- Al 0.05; Co 0.10; S 0.02; Se 0.005; Ti 0.05; Zr 0.05
- C 0.06; P 0.02

**max. impurities [wt.-%]**
- 0.50

**Technical data**
- Melting range of brazing alloy: approx. 970 - 1000 °C
- Optimum brazing temperature: approx. 1050 °C
- Density of brazing alloy: approx. 8.0 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 dPa.s (Haake Viscotester VT 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; 3; 5; 10; 25 kg

**Applications**
BrazeTec D 1002.1 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 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.

Nitrogen containing atmospheres are not suitable for this brazing alloy.

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