Technical Data Sheet BrazeTec D 1130.2

Standard
BrazeTec Standard (ISO 3677) (B-Ni72Cr18SiP-1050/1090)

Nominal composition [wt.-%]
- Ni Rem.; Cr 18.0; Si 8; P 2
- Permitted impurities max. [wt.-%]
  - Co 0.10; B 0.03; C 0.06; Al 0.05; Cd 0.010; Pb 0.025;
  - S 0.02; Se 0.005; Ti 0.05; Zr 0.05

max. impurities [wt.-%] 0.50

Technical data
- Melting range of brazing alloy approx. 1050 - 1090 °C
- Optimum brazing temperature approx. 1080 °C
- Density of brazing alloy approx. 7.7 g/cm³
- Density of brazing paste approx. 3.8 g/cm³ (20 °C)
- Metal content approx. 85 wt.-%
- Grain size of brazing alloy powder < 106 µm
- Viscosity 400 - 550 dPas (Haake Viscotester 2plus, Sp.2, 20 ± 2 °C)
- Cleaning agent Water
- Shelf life Can / bucket: min. 6 months
  - Cartridge: min. 3 months in the original closed container.
  - Storage temperature +5 to +30 °C.
  - Stir cans and buckets well before use.

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

Applications
BrazeTec D 1130.2 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.
The brazing process has to be carried out in vacuum or protective atmosphere.

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