

## Technical Data Sheet BrazeTec D 1090.1

### Standard

BrazeTec Standard  
(ISO 3677)

(B-Ni60CrPSi-980/1040)

### Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

max. impurities [wt.-%]

Ni Rem.; Cr 30.0; P 6.0; Si 4.0

Co 0.10; B 0.03; C 0.06; Al 0.05; Cd 0.010; S 0.02; Se 0.005;  
Ti 0.05; Zr 0.05

0.50

### Technical data

Melting range of brazing alloy

approx. 980 - 1040 °C

Optimum brazing temperature

approx. 1090 °C

Density of brazing paste

approx. 3.8 g/cm<sup>3</sup> (20 °C)

Metal content

approx. 85 wt.-%

Grain size of brazing alloy powder

< 53 µm

Viscosity

400 - 550 dPas (Haake Viscotester VT 02, Sp.2, 20 ± 2 °C)

Evaporation temperature of binder

approx. 400 °C at 1 bar

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 1090.1 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.

The brazing process should include a holding time at 400 °C to ensure a residue free burn-out of the binder.

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