

Technical Data Sheet BrazeTec D 1135.2

Standard

ISO 17672	Ni 650
(US-Standard ANSI/AWS A5.8)	(BNi-5)
(DIN EN 1044)	(NI 105)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]	Ni Rem.; Cr 19.0; Si 10.1
	Co 0.10; B 0.03; C 0.06; P 0.02; 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. 1080 - 1135 °C
Optimum brazing temperature	approx. 1190 °C
Density of brazing alloy	approx 7.7 g/cm ³
Density of brazing paste	approx. 3.8 g/cm ³ (20 °C)
Metal content	approx. 85 wt.-%
Grain size of brazing alloy powder	< 106 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	1.25; 3; 5; 10; 25 kg
----------	-----------------------

Applications

BrazeTec D 1135.2 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, and in some cases for special metals and their alloys.

The brazing process has to be carried out in vacuum or protective atmosphere.

Details in product brochures or other advertisements about our products, equipment, plant and processes are based on our research and our experience in the field of applied engineering and are merely recommendations. It is not possible to infer any warranted qualities or warranted use from these details, unless they were expressly agreed as a warranted quality. We reserve the right to make technical modifications in the course of our product development.

The user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. This shall also apply to the protection of third party property rights as well as to applications and processes. The properties of samples and specimens are binding only if these have been expressly agreed to define the quality of the goods. Information on the quality and durability and other particulars are warranted only if these are agreed and designated as such. The specifications agreed with the user/purchaser in writing are relevant for the quality of the goods and if specifications have not been agreed in writing, the information contained in our technical data sheets, specifications or drawings.

Any additional or diverging agreements on the quality must be in writing. Any suitability of the product for the presupposed or customary use which supplements or diverges from the agreed quality is out of the question. Our General Conditions of Sale and Delivery shall apply; the current version is available at www.umicore-brasage.fr/.