TD-STM-BT-E-1154-00

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.-%]	Ni Rem.; Cr 19.0; Si 10.1
Permitted impurities max. [wt.-%]	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/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 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.

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