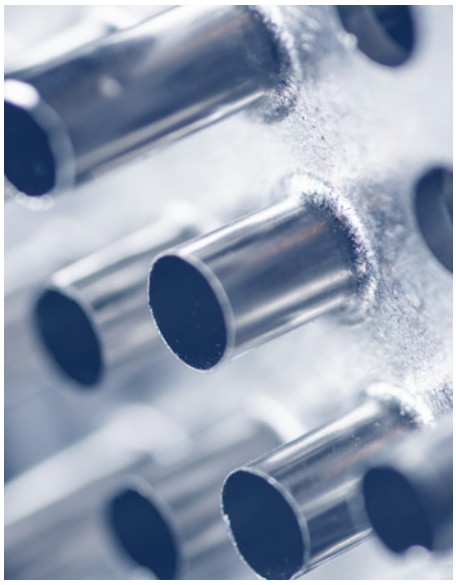

Dispensing

BrazeLet® Ni613DW-9205

Alloy Application BrazeLet Ni613

Naming	*BrazeLet Ni613*
Composition	*B-Ni60CrPSi*
Melting temperature	*970-1030°C (1778-1886°F)*
Min. brazing temperature	*1090°C (1994°F)*
Impurities	*According to ISO 17672 and ANSI/AWS A5.8*

BrazeLet Ni613, a nickel (Ni) based brazing alloy, features a best in class wetting behaviour on stainless steel material in vacuum or protective atmosphere. Its high level of alloyed chromium (Cr) results in a superior hot gas and acid corrosion resistance. The brazing alloy is best suited for brazing heat exchangers such as exhaust gas recirculation (EGR) cooler in automotive or tap water applications in home or industry.

Unlike the standardised Ni-based alloys, **BrazeLet Ni613** is able to fill gap sizes of <0.05 mm to 0.2 mm without brittle phase lines or cracks. The resulting micro hardness of the brazing area is less than half of a Ni650 brazing gap. This leads to a more reliable and safe brazing.

Paste Application Dispensing

Metal content	*92%*
Powder size	*<106 µm*
Typical density	*4.7 g/cm³*
Flash point of solvent	*-*
Recommended drying	*100-170°C (212-338°F)*
Evaporation temperature of binder	*Approx. 300-400°C (572-752°F)*
Cleaning	*Water*
Shelf life	*6 months in cartridges*
Storage	*Origin closed at 4 to 30°C (39-86°F)*
Typical Viscosity, Brookfield T-spindle D with Helipath, Speed 2.5 rpm, 20°C (70°F)	*350 Pas*

The water-based brazing paste **BrazeLet Ni613DW-9205** can be used for dispensing applications, typically found on heat exchanger inlet and outlet tubes, housing to core joints and hole plate to tube joints. It can be dispensed by using standard air pressure dispensing units. For better precision, screw dispense units are recommended. **BrazeLet Ni613DW-9205** sticks on all bevel and vertical positions without the need of pre-drying but is easily removed using water. The binder prevents pre-oxidation of Ni613-powder in trivial furnace atmospheres. This results in a residue-free brazed joint. **BrazeLet Ni613DW-9205** properties allow reliable application in a wide speed range as a result of the dispensing equipment / automatisation as well as the needle diameter. The paste can be delivered in 4 kg cartridges for use in automated applications or different sized cans for refilling of smaller cartridges for manual applications. For best performance when opening a can from stock it is always recommended to stir it.

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Customer support is provided every step of the way. We are deeply involved with you prior to delivery, offering expert advice to ensure an optimum solution. The Höganäs tech centres are well equipped to support all kinds of trials for roller coating applications and the parameters can be targeted at customers' process. We can provide test series of components with paste applied the same way as in final production in order to make sure the customers' productivity and quality requirements are fulfilled.

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