



## Dispensing **BrazeLet® Ni2DW-9007**

### Alloy Application BrazeLet Ni2

Naming	Ni620 according to ISO 17672 BNi-2 according to ANSI/ AWS A5.8
Composition	B-Ni82CrSiBFe according to ISO 17672 and ANSI/AWS A5.8
Melting temperature	970-1000 °C (1778-1832 °F)
Min. brazing temperature	1050 °C (1920 °F)
Impurities	According to ISO 17672 and ANSI/AWS A5.8

### Paste Application Dispensing

Metal content	90 %
Powder size	<106 µm
Typical density	4.5 g/cm³
Recommended drying	RT-150 °C (RT-302 °F)
Evaporation temperature of binder	Approx. 250-300 °C (482-572 °F)
Cleaning	Water
Shelf life	12 months
Storage	Origin closed at -20 to 35 °C (-4 to 95 °F). In cartridges 4 to 35 °C (39 to 95 °F)
Typical Viscosity, Brookfield T-spindle E with Hellipath, Speed 2.5 rpm, 20 °C (70 °F)	1200 Pas

The nickel (Ni) based brazing alloy **BrazeLet Ni2** is suitable for brazing stainless steel or super alloy materials in vacuum or nitrogen-free protective atmosphere. **BrazeLet Ni2** contains boron as a melting point depressant and can therefore be brazed at relatively low temperatures. It provides excellent high temperature strength and oxidation resistance. It is a versatile brazing filler metal used in aerospace, automotive and industrial applications such as heat exchangers and turbines.

As **BrazeLet Ni2** is sensitive to gap thickness, it is recommended that gaps do not exceed 50 µm. Wider gaps risk the formation of a crack-sensitive brittle centre line.

The water-based brazing paste **BrazeLet Ni2DW-9007** 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. The paste dries quickly, sticks to all bevel and vertical positions without the need of predrying. **BrazeLet Ni2DW-9007** can be easily removed with water. It has a very low polymer content. The flux-free binder is specially designed to decompose cleanly at low temperatures. In this way furnace maintenance is minimized, while preventing pre-oxidation of Ni2-powder in trivial furnace atmospheres.

**Brazelet Ni2DW-9007** achieves extremely good residue-free brazing results in both vacuum and continuous belt furnace brazing. Its properties allow reliable application in a wide speed range as a result of the dispensing equipment / automation as well as the needle diameter. The paste can be delivered in cartridges for use in automated applications or different sized cans. It can be frozen and brought back to room temperature for use without any damage to its properties.