FONTARGEN HTL 1

Nickel-based high-temperature brazing paste

DIN EN 1044:	NI 101
DIN 8513:	L-Ni1
EN ISO 3677:	B-Ni74CrFeSiB(C)-980/1060
AWS:	BNi-1
AMS:	4775 G
Boing:	BTS 1025-4

Composition, typical analysis (% w/w)**:**

Cr	Si	B	Fe	C	P	Ni
14	4.5	3.2	4.5	0.75	< 0.02	Remainder

Mechanical and physical properties:

Working temperature:	1066 - 1204 °C
Melting range:	980 - 1060 °C
Gap width:	0.05 - 0.15 mm
Viscosity range:	55.000 - 65.000 mPas
Metal content:	≈ 90 % w/w
Oxidationresistant up to:	1200 °C
Shear strength:	383 N/mm^2 (1.4006)
(at room temperature)	334 N/mm^2 (1.4301)

Characteristics / Applications:

This brazing alloy achieves good stability, is heat- and oxidationresistant and offers good diffusibility. Suitable for joints which are exposed to high thermal and dynamic stress, e.g. turbine blades as well as assemblies in the hot area of steel engines. Steel-, nickel-, cobalt and special materials. Suitable for workpieces with thicker cross sections.

Application:

Manually or automatically with pneumatical or mechanical dispensing units.

Heat sources:

Inert-gas continuous furnace Argon	Inert-gas continuous furnace Hydrogen	Vacuum furnace
☐	☒	☒

Availability:

Paste HTL 1 AP	Powder HTL 1
☒	☒

13/10/JL/1