

FONTARGEN HTL 6

Nickel-based high-temperature brazing paste



DIN EN ISO 17672:	Ni 700
DIN EN 1044:	Ni 106
DIN 8513:	L-Ni6
EN ISO 3677:	B-Ni89P-875
AWS:	BNi-6

Composition, typical analysis (% w/w):

P	C	Ni
11	< 0.06	Remainder

Mechanical and physical properties:

Working temperature:	927 - 1093 °C, rec. brazing temp. 980 °C
Melting range:	875 °C
Gap width:	up to 0.05 mm
Viscosity range:	60.000 - 80.000 mPas
Metal content:	≈ 90 % w/w
Oxidationresistant up to:	760 °C

Characteristics / Applications:

The brazing alloy HTL 6 has outstanding wetting properties. No erosion occurs while brazing on Fe- or Ni-based materials. The brazing alloy is applicable on currentless NiP-coated assemblies. Iron-, nickel-, cobalt- and special materials. Suited for workpieces which come in contact with food. Good flowing properties at low diffusibility.

Application:

Manually or automatically with pneumatical or mechanical dispensing units.

Heat sources:

Inert-gas continuous furnace Exogas / cracked NH ₃	Inert-gas continuous furnace Hydrogen	Vacuum furnace
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Availability:

Paste HTL 6 AP	Powder HTL 6
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13/10/JL/1