

# FONTARGEN HTL 7

## Nickel-based high-temperature brazing alloy



DIN EN ISO 17672:	Ni 710
DIN EN 1044:	Ni 107
DIN 8513:	L-Ni7
EN ISO 3677:	B-Ni76CrP-890
AWS:	BNi-7

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

Cr	P	C	Fe	Si	B	Ni
14	10.1	< 0.06	< 0.2	< 0.1	< 0.01	Remainder

### Mechanical and physical properties:

Working temperature:	927 - 1093 °C, rec. brazing temp. 980 °C
Melting range:	890 °C
Gap width:	up to 0.05 mm
Viscosity range:	60.000 - 80.000 mPas
Metal content:	≈ 90 % w/w
Oxidationresistant up to:	855 °C

### Characteristics / Applications:

The brazing alloy HTL 7 is used for thin-walled tubes, honeycomb-structures as well as assemblies for the nuclear technology. It is easy to dispense and dries slowly on air. It is very well suited for high-tensile, vacuum-sealed, high-temperature- and corrosionresistant joints. Suited for parts which come in contact with food. The ductility of the brazing joint can be enhanced by an extension of the exposure time. Iron-, nickel-, cobalt and special materials are applicable. Good flowing properties at low diffusibility.

### Application:

Manually or automatically with pneumatical or mechanical dispensing units.

### Heat sources:

Inert-gas continuous furnace cracked NH <sub>3</sub>	Inert-gas continuous furnace Hydrogen	Vacuum furnace
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### Availability:

Paste HTL 7 AP	Powder HTL 7
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