FONTARGEN HTL 8

Nickel-based high-temperature brazing paste

DIN EN ISO 17672:	Ni 800
DIN EN 1044:	NI 108
DIN 8513:	L-Ni8
EN ISO 3677:	B-Ni66MnSiCu-980/1010
AWS:	BNi-8

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

Mn	Cu	Si	C	P	Ni
23	4.5	7	< 0.06	< 0.02	Remainder

Mechanical and physical properties:

Working temperature:	1010 - 1093 °C, rec. brazing temp. 1065 °C
Melting range:	890 - 1010 °C
Gap width:	up to 0.05 mm
Oxidationresistant up to:	816 °C

Characteristics / Applications:

The flux-free brazing alloy HTL 8 is used for brazing of heat exchangers, honeycomb-structures as well as temperable or stainless steel. The operation of this brazing alloy requires a very good furnace atmosphere. Iron-, nickel-, cobalt- and special materials are to be brazed with this alloy. Good flowing properties at low diffusibility.

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 8 AP	Powder HTL 8
☒	☒

13/10/JL/1