



BrazeLet™ F300 – For High End Applications

BrazeLet™ F300 is a FeCr-based stainless filler metal powder developed for high temperature brazing of stainless steels. The unique chemical composition of BrazeLet™ F300 offers similar properties to high performing Ni-based filler metals, but at an attractive and stable metal cost.

The optimal application medium for BrazeLet™ F300 stainless filler metal powders is as a paste. The paste can be applied via conventional techniques such as dispensing, roller coating, screen printing and spraying. Paste application technology solutions are offered in cooperation with highly recommended partners.

For more information on BrazeLet™ or any other product from Höganäs, please contact your local sales representative.

Benefits

- Cost-efficient
- Wide gap flexibility
- Corrosion resistant
- High strength



BrazeLet™ F300 Technical Data

BrazeLet™ F300 is gas atomised to form the unique chemical composition resulting in the advantageous properties found during brazing and in the final joint.

Comp. weight %	Fe	Cr	Ni	P	Si	Cu	Mn
BrazeLet™ F300	Bal	24	20	7	5	10	5

The recommended brazing temperature for BrazeLet™ F300 is 1120°C / 2050°F in a vacuum or a controlled atmosphere.

Wetting Properties

BrazeLet™ F300 wetting properties exceed most Ni-based filler metals. The spreading ratio, defined as the area of the melted powder and the area of initial powder, A_m/A_i . The excellent wetting properties result in wide gap flexibility.

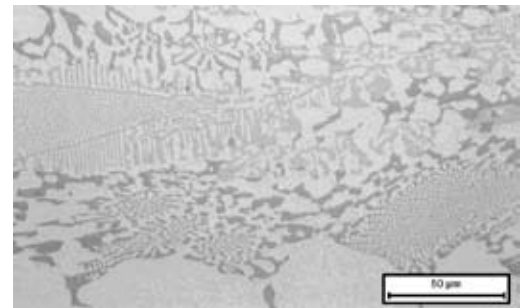
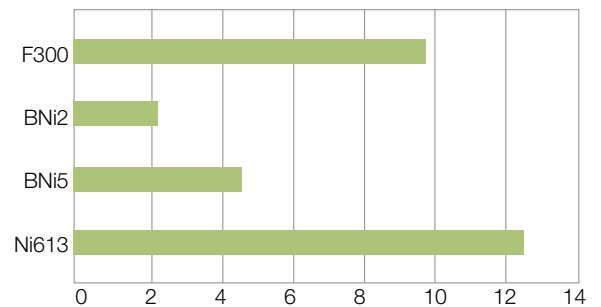
Microstructure and Strength

The microstructure of BrazeLet™ F300 contains a homogenous mix of a hard phase surrounded by a ductile phase – a combination that results in high strength. This structure remains during wide gap brazing and no segregation can be detected. The joint fillet is crack free.

Corrosion Resistance

BrazeLet™ F300 has excellent corrosion and oxidation resistance to different acids (HCl, HNO₃, H₂SO₄), similar to the high-performing BrazeLet™ Ni613.

Spreading ratio



Joint strength

