



Dispensing **BrazeLet® F300DW-9201**

Alloy application BrazeLet F300-20

Naming	BrazeLet F300-20
Composition	B-Fe42CrNiPCuSi
Melting temperature	1025–1060 °C (1877–1940 °F)
Min. brazing temperature	1100 °C (2012 °F)
Impurities	According to ISO 17672 and ANSI/AWS A5.8

BrazeLet F300-20, a stainless based brazing alloy, features a best in class wetting behaviour on stainless steel material in vacuum or protective atmosphere. Its high level of alloyed chromium (Cr) results in a superior hot gas and acid corrosion resistance. The brazing alloy is best suited for brazing of heat exchangers, stainless oil coolers for commercial vehicles, exhaust gas recirculation (EGR) coolers in automotive or tap water applications in household or industry.

Unlike the standardised nickel (Ni) based alloys, **BrazeLet F300-20** is able to fill gap sizes of <0.05 mm to 0.2 mm without brittle phase lines or cracks. The resulting micro hardness of the brazing area is less than half of a Ni650 brazing gap. This leads to a more reliable and safe brazing as well as more flexibility in part tolerances.

Paste application dispensing

Metal content	92%
Powder size	<106 µm
Typical density	4.6 g/cm ³
Flash point of solvent	>75 °C (167 °F)
Recommended drying	120–150 °C (248–302 °F)
Evaporation temperature of binder	Approx. 300–400 °C (572–752 °F)
Cleaning	Water
Shelf life	12 months / 4 months in cartridges
Storage	Origin closed at 4–30 °C (39–86 °F)
Typical Viscosity, Brookfield T-spindle E with Helipath, Speed 2.5 rpm, 20 °C (70 °F)	1000 Pas

The brazing paste **BrazeLet F300DW-9201** can be used for dispensing applications, typically found on heat exchanger inlet and outlet tubes, housing to core joints and hole plate to tube joints. It can be dispensed by using standard air pressure dispensing units. For better precision, screw dispense units are recommended. The paste sticks on all bevel and vertical positions without the need of pre-drying but is easily removed using water. **BrazeLet F300DW-9201** properties allow reliable application in a wide speed range as a result of the dispensing equipment / automation as well as the needle diameter. The paste can be delivered in cartridges for use in automated applications or different sized cans for refilling of smaller cartridges for manual applications. For best performance, it is recommended to first stir the paste.