The signature of Ni Brazing Quality
BrazeLet Ni685 is a Ni-based filler metal powder for high temperature brazing developed specifically for EGR coolers, but it is also suitable for all types of applications in high temperature and high corrosion environments.

The unique composition of BrazeLet Ni685 offers an attractive combination of properties such as excellent wetting, high strength, and high corrosion and oxidation resistance.

The optimal application medium for BrazeLet Ni685 filler metal powders is as a paste. The paste can be applied via conventional techniques such as dispensing, roller coating, screen printing and spraying. Höganäs provides a complete range of pastes for all application solutions.

For more information on BrazeLet and other Höganäs products, please contact your local sales representative.

BrazeLet® Ni685

Benefits:
• Cost-efficient
• Gap size flexibility
• Corrosion resistant
• High strength

Alloy Application BrazeLet Ni685

<table>
<thead>
<tr>
<th>Naming:</th>
<th>BrazeLet Ni685</th>
</tr>
</thead>
<tbody>
<tr>
<td>Composition:</td>
<td>B-Ni60CrPSi</td>
</tr>
<tr>
<td>Melting temperature:</td>
<td>970-1030°C</td>
</tr>
<tr>
<td>Min. brazing temperature:</td>
<td>1090°C</td>
</tr>
<tr>
<td>Impurities:</td>
<td>According to ISO 17672 and ANSI/AWS A5.8</td>
</tr>
</tbody>
</table>
BrazeLet® Ni685 Technical Data

Unique Chemical Composition
BrazeLet Ni685 is gas atomised into spherical particles to form a unique chemical composition resulting in the advantageous properties found during brazing and in the final joint.

<table>
<thead>
<tr>
<th>Comp. weight %</th>
<th>Ni</th>
<th>Cr</th>
<th>P</th>
<th>Si</th>
</tr>
</thead>
<tbody>
<tr>
<td>BrazeLet Ni685</td>
<td>Bal.</td>
<td>29</td>
<td>6</td>
<td>4</td>
</tr>
</tbody>
</table>

The recommended brazing temperature for BrazeLet Ni685 is 1090°C / 1994°F in a vacuum or a controlled atmosphere.

Wetting Properties
BrazeLet Ni685 has excellent wetting properties, which exceed most Ni-based filler metals. During brazing the alloy fills gap sizes up to 0.46 mm and is not sensitive to uneven gaps. The excellent wetting properties also lead to direct cost savings, as a lower amount of filler metal is needed compared to conventional Ni-based filler metals.

Microstructure and Strength
The microstructure of BrazeLet Ni685 contains a homogeneous 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 Ni685 displays better corrosion resistance than BNi5, but can still be brazed at lower temperatures. Corrosion resistance has been proven against acids such as HCl, HNO3 and H2SO4.