Dispensing BrazeLet® Ni7DW-9201

The nickel (Ni) based brazing alloy BrazeLet Ni7 is a low-melting, eutectic brazing alloy suitable for brazing in vacuum or protective atmosphere. It is suitable for brazing thin-walled assemblies due to its free-flowing ability, and provides good oxidation and corrosion resistance at elevated temperatures. It is typically used for tube-fin heat exchangers or applications where the base material is sensitive to higher brazing temperatures.

As BrazeLet Ni7 is sensitive to gap thickness, it is recommended that gaps do not exceed 30 μm. Wider gaps risk the formation of a crack-sensitive brittle centre line.

The brazing paste BrazeLet Ni7DW-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 Ni7DW-9201 properties allow reliable application in a wide speed range as a result of the dispensing equipment / automatisation as well as the needle diameter. The paste can be delivered in 4 kg 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.

Customer support is provided every step of the way. We are deeply involved with you prior to delivery, offering expert advice to ensure an optimum solution. The Höganäs tech centres are well equipped to support all kinds of trials for roller coating applications and the parameters can be targeted at customers’ process. We can provide test series of components with paste applied the same way as in final production in order to make sure the customers’ productivity and quality requirements are fulfilled.

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