



## The BrazeLet® BNi Family

### Meeting Different Needs

The BrazeLet BNi family offers nickel-based filler metal powders suitable for different applications, brazing conditions and braze properties. Applications are found in a wide range of automotive as well as industrial areas. Typical automotive applications are EGR-coolers (Exhaust Gas Recirculation) for diesel as well as gasoline engines, catalytic converters and fuel rails. Brazed plate heat exchangers, heaters and boilers are common industrial applications.

The different filler metals within the BrazeLet BNi family are highly suitable for brazing of stainless steels, as well as Ni and Co-based alloys. For Ni-based filler metals, the most established process is furnace brazing in a vacuum or a controlled atmosphere.

The optimal application medium for BrazeLet BNi filler metal powders is as a paste via conventional application 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® BNi Family Technical Data

All BrazeLet filler metals are gas atomised into well-defined chemical compositions. The chemical composition of each filler metal determines the properties during brazing and of the final joint.

Product	AWS A5.8	EN ISO 17672	Ni	Cr	B	P	Si	Fe	C	Melting Range °C / °F
BrazeLet BNi1	BNi-1	Ni 600	Bal.	13.0-15.0	2.75-3.50	max. 0.02	4.0-5.0	4.0-5.0	0.60-0.90	980-1060 1796-1940
BrazeLet BNi1A	BNi-1a	Ni 610	Bal.	13.0-15.0	2.75-3.50	max. 0.02	4.0-5.0	4.0-5.0	max 0.06	977-1077 1790-1970
BrazeLet BNi2	BNi-2	Ni 620	Bal.	6.0-8.0	2.75-3.50	max. 0.02	4.0-5.0	2.5-3.5	max 0.06	970-1000 1778-1832
BrazeLet BNi3	BNi-3	Ni 630	Bal.	-	2.75-3.50	max. 0.02	4.0-5.0	max. 0.5	max 0.06	980-1040 1800-1900
BrazeLet BNi4	BNi-4	Ni 631	Bal.	-	1.50-2.20	max. 0.02	3.0-4.0	max 1.5	max 0.06	980-1065 1800-1950
BrazeLet BNi5	BNi-5	Ni 650	Bal.	18.5-19.5	max. 0.03	max. 0.02	9.7-10.5	-	max 0.06	1080-1135 1976-2075
BrazeLet BNi6	BNi-6	Ni 700	Bal.	-	-	10.0-12.0	-	-	max 0.06	875 1607
BrazeLet BNi7	BNi-7	Ni 710	Bal.	13.5-15.0	max. 0.02	9.7-10.5	max. 0.1	max. 0.2	max 0.06	890 1634
BrazeLet BNi9	BNi-9	Ni 612	Bal.	13.5-16.5	3.25-4.00	max. 0.02	-	max. 1.5	max 0.06	1055 1931
BrazeLet BNi12	BNi-12	Ni 720	Bal.	24.0-26.0	max. 0.02	9.0-11.0	max. 0.1	max. 0.2	max 0.06	880-950 1616-1742