



Dispensing BrazeLet® F86DW-9013

Alloy Application BrazeLet F86

Naming	BrazeLet F86
Composition	B-Fe40CrNiSiP(Nb)
Melting temperature	1,050-1,100°C (1,922-2,012°F)
Min. brazing temperature	1,150°C (2,102°F)
Impurities	According to ISO 17672 and ANSI/AWS A5.8

Paste Application Dispensing

Metal content	90%
Powder size	<63 µm
Typical density	4.4 g/cm³
Recommended drying	100-170°C (212-338°F)
Evaporation temperature of binder	Approx. 300-400°C (572-752°F)
Cleaning	Water
Shelf life	12 months in cans or buckets / 6 months in cartridges
Storage	Origin closed at 4 to 30°C (39-86°F)
Typical Viscosity, Brookfield T-spindle D with Hellpath, Speed 2.5 rpm, 20°C (70°F)	300 Pas

BrazeLet F86, is a FeCr-based stainless filler metal powder developed for high temperature brazing of stainless steels. The unique chemical composition of **BrazeLet F86** offers similar properties to highperforming Ni-based filler metals, but at a more attractive and stable metal cost. Compared to Höganäs' other iron-based brazing filler metals, **BrazeLet F86** offers higher joint strength while still maintaining the good corrosion resistance, high-temperature oxidation resistance and gap filling abilities.

Unlike the standardised nickel (Ni) based alloys, **BrazeLet F86** is able to fill gap sizes of <0.05 mm to 0.2 mm without brittle phase lines or cracks. flexibility in part tolerances.

The water-based brazing paste **BrazeLet F86DW-9013** 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 predrying, but is easily removed using water.

BrazeLet F86DW-9013 properties allow reliable application in a wide speed range as a result of the dispensing equipment / automatization 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 stir the paste before use.