



Dispensing **BrazeLet® Ni2DW-9003**

Alloy Application BrazeLet Ni2

Naming	Ni620 according to ISO 17672 BNi-2 according to ANSI/ AWS A5.8
Composition	B-Ni82CrSiBFe according to ISO 17672 and ANSI/AWS A5.8
Melting temperature	970-1000 °C (1778-1832 °F)
Min. brazing temperature	1050 °C (1922 °F)
Impurities	According to ISO 17682 and ANSI/AWS A5.8

Paste Application Dispensing

Metal content	90%
Powder size	<106 µm
Typical density	4.4 g/cm³
Flash point of solvent	-
Recommended drying	100-150 °C (212-302 °F)
Evaporation temperature of binder	Approx. 300-400 °C (572-752 °F)
Cleaning	Water
Shelf life	12 months in cans
Storage	Origin closed at 4 to 30 °C (39-86 °F)
Typical Viscosity, Brookfield T-spindle D with HeliPath, Speed 2.5 rpm, 20 °C (70 °F)	300 Pas

The nickel (Ni) based brazing alloy **BrazeLet Ni2** is suitable for brazing stainless steel or super alloy materials in vacuum or nitrogen-free protective atmosphere. **BrazeLet Ni2** contains boron as a melting point depressant and can therefore be brazed at relatively low temperatures. It provides excellent high temperature strength and oxidation resistance. It is a versatile brazing filler metal used in aerospace, automotive and industrial applications such as heat exchangers and turbines.

As **BrazeLet Ni2** is sensitive to gap thickness, it is recommended that gaps do not exceed 50 µm. Wider gaps risk the formation of a crack-sensitive brittle centre line.

The water-based brazing paste **BrazeLet Ni2DW-9003** 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 Ni2DW-9003 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 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.