Höganäs BrazeLet pastes go through a series of stages during a standard brazing cycle.

The paste starts off as wet, containing metal powder, polymer and solvent. As temperature increases the solvent evaporates leaving dry paste. Next, the polymer burns off and leaves only the metal particles, which then start to sinter. Lastly the melt initiates and the filler metal starts to flow and fill gaps by capillary force.

When the different stages occur depends on the paste and brazing filler metal.

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

Data for Höganäs BrazeLet F300:
- Drying: 20°C - 170°C, depending on binder
- Debinding: 300°C - 450°C depending on binder
- Melt initiation: 1000°C - 1030°C
- Metallic residue: 1040°C - 1060°C
- Full braze: 1100°C

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