



Dispensing **BrazeLet® Ni7DW-9201**

Alloy Application BrazeLet Ni7

Naming	Ni 710 according to ISO 17672 BNi-7 according to ANSI/ AWS A5.8
Composition	B-Ni76CrP according to ISO 17672 and ANSI/AWS A5.8
Melting temperature	890°C (1634°F)
Min. brazing temperature	980°C (1796°F)
Impurities	According to ISO 17682 and ANSI/AWS A5.8

Paste Application Dispensing

Metal content	92%
Powder size	<106µm
Typical density	4.6 g/cm³
Flash point of solvent	>75°C (167°F)
Recommended drying	120-150°C (248-302°F)
Evaporation temperature of binder	Approx. 300-400°C (572-752°F)
Cleaning	Water
Shelf life	12 months in can / 4 months in cartridges
Storage	Origin closed at 4 to 30°C (39-86°F)
Typical Viscosity, Brookfield T-spindle E with Hellpath, Speed 2.5 rpm, 20°C (70°F)	Approx. 1000 Pas

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 / 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.