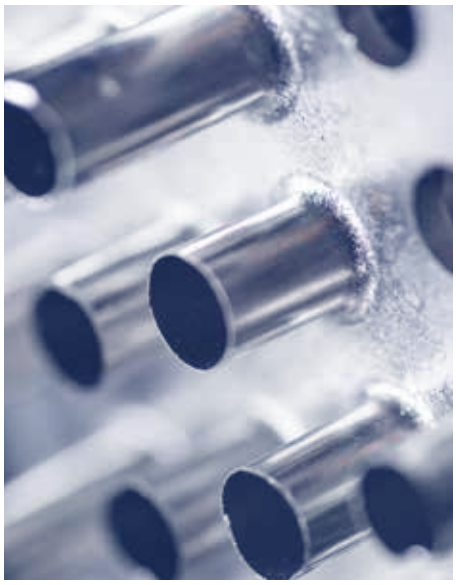

Dispensing
BrazeLet® SS316DW-8893

Alloy Application BrazeLet SS316

Naming	*BrazeLet SS316*
Composition	*EN X2CrNiMo 17-12-2*
Melting temperature	*1371-1399° C (2450-2550° F)*
Min. brazing temperature	*According to the used brazing filler metal but should not exceed 1190° C (2174° F)*

Höganäs **BrazeLet SS316DW-8893** paste is developed for brazing of very big gaps (from 0.5 mm to around 3 mm). Traditionally, brazing filler materials are to be used for brazing gaps <0.1 mm. When not possible to design an optimum joint condition, this stainless paste for big gaps can be used. The 316L stainless powder particles divide one big original gap in hundreds of small gaps, giving back capillary force for brazing operation in vacuum or protective atmosphere.

The austenitic 316L stainless steel powder has a superior hot gas and acid corrosion resistance, same as the base material typical in use.

Paste Application Dispensing

Metal content	*88 %*
Powder size	*20-55 µm*
Typical density	*4.1 g/cm³*
Recommended drying	*100-170° C (212-338° F)*
Evaporation temperature of binder	*Approx. 300-400° C (57-752° F)*
Cleaning	*Water*
Shelf life	*12 months in can or buckets*
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)	*350 Pas*

BrazeLet SS316DW-8893 is suitable to be used together with any of the filler metals, e.g. Ni613. It is of great importance to apply the stainless paste exactly where it is needed as well as controlling the amount of paste applied. Furthermore, the stainless paste must be applied inside the gap area, filling out the complete space. During brazing, the 316L will stay where it has been applied. The application of brazing paste will proceed as usual from outside of the gap. The braze alloy will melt, infiltrate and fill the many micro gaps without brittle phase lines or cracks. Excessive application of **BrazeLet SS316DW-8893** outside the joint area would remain visible after brazing as metallic elevations as the stainless 316L particles does not melt.

As a practical approach, the required paste weight should be determined from the gap volume (cm^3) and the **BrazeLet SS316DW-8893** paste density (g/cm^3). As a starting point, the same amount of brazing filler metal as **BrazeLet SS316DW-8893** can be considered to completely fill the gap volume.

Höganäs

www.hoganasbrazing.com

Customer support is provided every step of the way. We are deeply involved with you prior to delivery, offering expert advice to ensure an optimum solution. The Höganäs tech centres are well equipped to support all kinds of trials for roller coating applications and the parameters can be targeted at customers' process. We can provide test series of components with paste applied the same way as in final production in order to make sure the customers' productivity and quality requirements are fulfilled.