

# FONTARGEN HTL 2

## Nickel-based high-temperature brazing paste



|                   |                        |
|-------------------|------------------------|
| DIN EN ISO 17672: | Ni 620                 |
| DIN EN 1044:      | NI 102                 |
| DIN 8513:         | L-Ni2                  |
| EN ISO 3677:      | B-Ni82CrSiBFe-970/1000 |
| AWS:              | BNI-2                  |
| AMS:              | 4777                   |
| Rolls Royce:      | 9500/97                |

### Composition, typical analysis (% w/w):

| Cr | Si  | B   | Fe | C      | P      | Ni        |
|----|-----|-----|----|--------|--------|-----------|
| 7  | 4.5 | 3.1 | 3  | < 0.06 | < 0.02 | Remainder |

### Mechanical and physical properties:

|                           |  |
|---------------------------|--|
| Working temperature:      | 1010 - 1170 °C, rec. brazing temp. 1080 °C |
| Melting range:            | 970 - 1000 °C                              |
| Gap width:                | 0.02 - 0.20 mm                             |
| Viscosity range:          | 55.000 - 65.000 mPas                       |
| Metal content:            | ≈ 90 % w/w                                 |
| Oxidationresistant up to: | 982 °C                                     |
| Shear strength:           | 383 N/mm <sup>2</sup> (1.4006)             |
| (at room temperature)     | 255 N/mm <sup>2</sup> (1.4301)             |

### Characteristics / Applications:

This brazing alloy has good flowing properties and offers good diffusibility and is easy to dispense. Suitable for joints which are exposed to high thermal and dynamic stress. The brazing alloy allows optimal processing on e.g. turbine blades as well as on assemblies for the hot area in steel engines. Iron-, nickel-, cobalt and special materials.

### Application:

Manually or automatically with pneumatical or mechanical dispensing units.

### Heat sources:

| Inert-gas continuous furnace<br>Argon | Inert-gas continuous furnace<br>Hydrogen | Vacuum furnace                      |
|---------------------------------------|--|-------------------------------------|
| <input checked="" type="checkbox"/>   | <input checked="" type="checkbox"/>      | <input checked="" type="checkbox"/> |

### Availability:

| Paste HTL 2 AP                      | Powder HTL 2                        |
|-------------------------------------|-------------------------------------|
| <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |

13/10/JL/1