



## Roller coating **BrazeLet® F300R-8501**

### Alloy application BrazeLet F300-20

Naming	BrazeLet F300-20
Composition	B-Fe42CrNiPCuSi
Melting temperature	1,025-1,060 °C (1,877-1,940 °F)
Min. brazing temperature	1,100 °C (2,012 °F)
Impurities	According to ISO 17672 and ANSI/AWS A5.8

**BrazeLet F300-20**, a stainless based brazing alloy, features a best in class wetting behaviour on stainless steel material in vacuum or protective atmosphere. Its high level of alloyed chromium (Cr) results in a superior hot gas and acid corrosion resistance. The brazing alloy is best suited for brazing of heat exchangers, stainless oil coolers for commercial vehicles, exhaust gas recirculation (EGR) coolers in automotive or tap water applications in household or industry.

Unlike the standardised nickel (Ni) based alloys, **BrazeLet F300-20** is able to fill gap sizes of <0.05 mm to 0.2 mm without brittle phase lines or cracks. The resulting micro hardness of the brazing area is less than half of a Ni650 brazing gap. This leads to a more reliable and safe brazing as well as more flexibility in part tolerances.

### Paste application roller coating

Metal content	85%
Powder size	<63 µm
Typical density	3.3 g/cm³
Flash point of solvent	>100 °C (212 °F)
Recommended drying	120-170 °C (248-338 °F)
Evaporation temperature of binder	Approx. 350-450 °C (662-842 °F)
Cleaning	Aliphatic solvents or Bio based solvents
Shelf life	18 months / 6 months in cartridges
Storage	Origin closed at 4-30 °C (39-86 °F)
Typical viscosity, Brookfield T-spindle C with helipath, speed 2.5 rpm, 20 °C (70 °F)	90 Pas

The brazing paste **BrazeLet F300R-8501** can be used for roller coating fins or structured plates, typically found in flat heat exchanger designs. Depending on type of roller used the paste can be applied with thin layers either on top or on the side of the fin tips. Gap size between paste roll and scraper of 0.08 to 0.12 mm is recommended. The amount of paste is controlled by weight and is a function of the fins or structured plate design. **BrazeLet F300R-8501** properties allow reliable application in a wide range of coating speeds, tested up to 20 m/min. The oil based paste ensures reliable coating over time without drying on the roll. It has no settlement and no stirring is needed in the equipment. However, when opening a can from stock it is always recommended to stir the paste.

The coated fins can be dried with standard drying process (hot air) at 120-170 °C. Here, the drying time depends on thermal mass, parts design and the used furnace and thus needs to be established. When dried, the paste has excellent adhesion to the metal sheet.