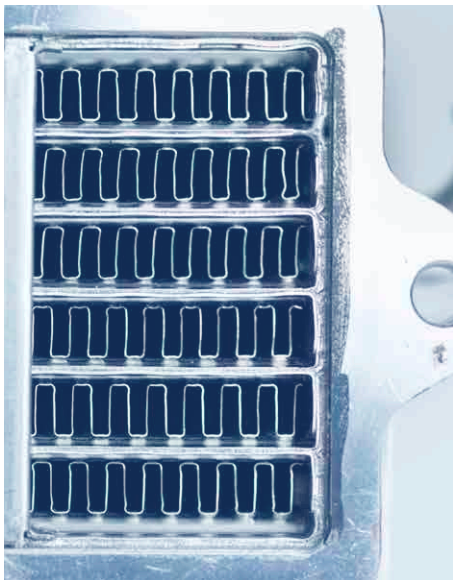

Roller coating
BrazeLet® Ni2R-8501

Alloy Application BrazeLet BNi2

Naming	*Ni 620 according to ISO 17672 BNi-2 according to ANSI/AWS A5.8*
Composition	*B-Ni82CrSiBFe according to ISO 17672 and ANSI/AWS A5.8*
Melting temperature	*970-1,000 °C (1,778-1,832 °F)*
Min. brazing temperature	*1,050 °C (1,922 °F)*
Impurities	*According to ISO 17682 and ANSI/AWS A5.8*

The nickel (Ni) based brazing alloy **BrazeLet BNi2** is suitable for brazing stainless steel or super alloy materials in vacuum or nitrogen-free protective atmosphere. **BrazeLet BNi2** contains boron as a melting point depressant and can therefore be brazed at relatively low temperatures. It provides excellent high temperature strength and oxidation resistance. It is a versatile brazing filler metal used in aerospace, automotive and industrial applications such as heat exchangers and turbines.

As **BrazeLet BNi2** is sensitive to gap thickness, it is recommended that gaps do not exceed 50 µm. Wider gaps risk the formation of a crack-sensitive brittle centre line.

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*
Shelf life	*18 months in cans / 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 Ni2R-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 Ni2R-8501** properties allow reliable application in a wide range of coating speeds, tested up to 20m/min. The solvent 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, **BrazeLet Ni2R-8501** has excellent adhesion to the metal sheet.

Höganäs

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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.