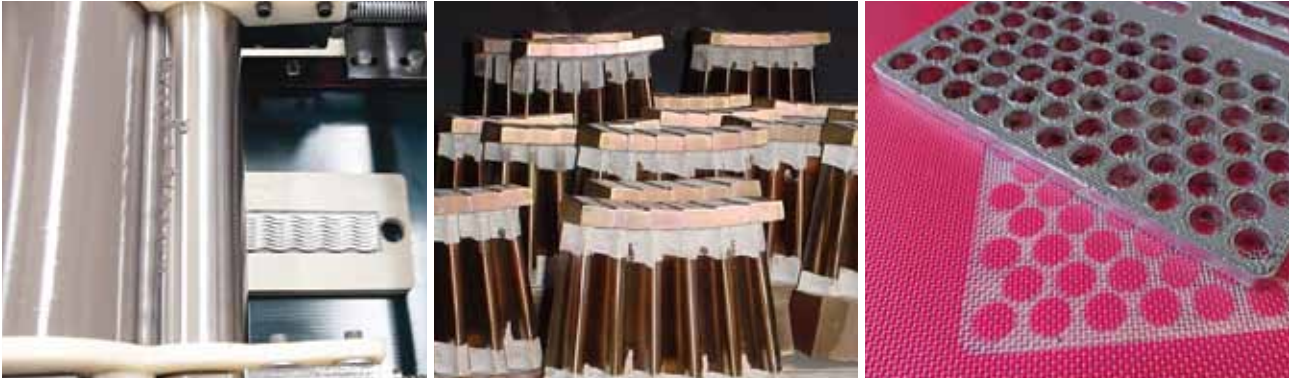


FORTEBRAZE

Brazing Powders and Pastes





Nickel and Cobalt-based Brazing Powders and Pastes

Applications

High strength, corrosion and oxidation resistance properties of nickel based brazing alloys made them ideally suited to join stainless steel parts. These alloys are used in aerospace, tool manufacturing, HVAC industries. Automotive parts like EGR coolers, catalytic converters and brazed plate heat exchangers some example of their applications.

Product Code	EN 1044	AWS A5.8	ISO 17672	Ni	Cr	Si	B	Other		Melting Range °C
9001	NI 101	BNi-1		75	14	4.5	3.1	4.5 Fe	0.75	980-160
9001A	NI 1A1	BNi-1a1	Ni 600	76	14	4.5	3.1	4.5 Fe		980-1070
9002	NI 102	BNi-2	Ni 612	82.4	7	4.5	3.1	3 Fe		970-1000
9003	NI 103	BNi-3	Ni 630	92.4		4.5	3.1			980-1040
9004	NI 104	BNi-4	Ni 631	93.7		3.5	2	0.75 Fe		980-1070
9005	NI 105	BNi-5	Ni 650	70.9	19	10.1				1080-1135
9006	NI 106	BNi-6	Ni 700	89				11 P		875
9007	NI 107	BNi-7	Ni 710	76	14			10 P		890
9008	NI 108	BNi-8	Ni 800	65.7		7		4.5 Cu	23 Min	980-1070
9009	NI 109	BNi-9	Ni 612	80.4	15		3.6	1 Fe		1055
9012		BNi-14	Ni 655	67.5	22	6		4 P		960-1080

Cobalt-Based Brazing Alloys

Product Code	EN 1044	AWS A5.8	ISO 17672	Co	Ni	Cr	Si	B	Other		Melting Range °C
9001	CO 101	BCo-1	Co 900	50.8	17	19	8	0.8	4 W	0.4 C	1120-1150



Copper-based Brazing Pastes

Various paste types has been developed for different applications, furnace atmospheres and brazing characteristics. ForteBraz paste do not leave residues, do not spatter and have high adhesion characteristics.

GF Series *Copper paste with gas atomised copper powder. Good fillet forming properties gives better appearance of joint. Used in cracked natural gas or propane, H₂/N₂ atmosphere furnaces.*

SF Series *Economical copper paste with water atomised copper powder. Used in cracked natural gas or propane, H₂/N₂ atmosphere furnaces.*

MF Series *Copper paste for vacuum or pure H₂ atmosphere furnace*

Product Code	EN 1044	AWS A5.8	ISO 17672	Cu	Sn	Ni	Other	Melting Range °C
11000	CU102	B-Cu1	Cu 102	99.95				1085
11000 GFx	CU103	B-Cu1a		99.9				1085
11000 SFx								
11000 MF3								
11000 MF5	CU102	B-Cu3	Cu 102	99.9				1085
11000 MF4	CU104	B-Cu1f	Cu 141	99.9			<0.03 P	1085
11200	CU105		Cu 186	97		2.5	0.03 B	1085-110
11310				87		3	10 Mn	980-1030
11401	CU108		Cu 188	99			1 Ag	1070-1080
12004				96	4		<0.03 P	960-1060
12006	CU201		Cu 922	94	6		<0.03 P	910-1040
12008				92	8		<0.03 P	880-1030
12012	CU202		Cu 925	88	12		<0.03 P	825-990



Copper-Phosphorus Brazing Pastes

Product Code	EN 1044	AWS A5.8	ISO 17672	Cu	P	Ag	Other		Melting Range °C
2006	CP203		CuP 179	93.8	6.2				710-890
2007	CP202	BCuP-2	CuP 180	93	7				710-820
2008	CP201		CuP 182	92.2	7.8				710-770
2077	CP302		CuP 386	86.2	6.8		Sn 7		650-700
3015	CP102	BCuP-5	CuP 102	80	7	15			645-800
3018	CP101		CuP 101	75	5	15			645
3666				72	6	6	Sn 6		600-640
2155				76	5		Sn 15	Ni 4	590-610

Binders

Binders have been developed for different application technologies.

Dispensing

For automatic or manual dosing.

Screen Printing

Binder developed for automated screen printing paste application.

Spraying

Thin layer of paste applied with spray air gun.

Roller Coating

Paste is applied on fins or structured plates by roller coating

Transfer Tape

Uniform layer of cast braze alloy and a binder wound in rolls with adhesive applied one side.



Silver Brazing Pastes with Flux

Applications

Silver brazing pastes with flux are used mostly for brazing carbides and steels with induction heating and non-protective atmospheres.

7072 brazing paste is eutectic alloy paste for joining copper, steels and ceramics under protective atmospheres.

Product Code	EN 1044	AWS A5.8	ISO 17672	Ag	Cu	Zn	Other		Melting Range °C
5040	AG304		Ag 340	40	19	21	Cd 20		595-630
7049	AG502	BAG-22	Ag 449	49	16	23	Ni 4.5	Mn 7.5	680-705
7051	AG351	BAG-3	Ag 351	50	15.5	15.5	Ni 3	Cd 16	635-655
6056	AG102	BAG-7	Ag 156	56	22	17	Sn 5		620-655

Silver Brazing Pastes without Flux

Product Code	EN 1044	AWS A5.8	ISO 17672	Ag	Cu	Melting Range °C
7072	AG401	BAG-8	Ag 272	72	28	780



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