



## ENAR WELD BRAZE PVT. LTD

A-112, DDA INDUSTRIAL SHEDS,  
OKHLA INDUSTRIAL AREA, PHASE – II  
NEW DELHI – 110020

Telephone : 011-26383911/12/13  
Fax : 011-26383913  
E-Mail : info@enarweld.com

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### ENAR NAFB Paste : Nickel Alloy Furnace Brazing Paste AWS A5.8 B Ni - 5

#### Unique Features:

A typically formulated paste with 99.9 % + purity fine mesh Ni-Cr-Si Alloy Powder having a metal content of 85% weight mixed with special binders.

#### Advantages:

This Nickel Brazing Alloy is usually used for furnace brazing of 300 & 400 series of Stainless Steels and High-Alloyed Steels, Nickel and Nickel alloys.

It provides high temperature joint strength plus oxidation, corrosion, and abrasion resistance on thick sections of stainless steel, ductile nickel, and cobalt base alloys.

It is ideal for joints for elevated temperature services and for brazing Heat Exchangers, EGR Coolers and Honeycomb component assemblies providing strong, leak-proof joints.

The brazing process has to be carried out in vacuum or controlled atmosphere.

**Brazing Temp:** 1150-1200°C

**Solidus to Liquidus Temp:** 1065-1135°C.

This filler metal is very fluid and works best with joint clearances less than 0.02 to 0.15 MM.

#### Typical Chemistry of Deposit:

| <b>Composition, typical analysis (% w/w):</b> |         |              |         |         |           |
|---|---------|--------------|---------|---------|-----------|
| Cr  | Al      | Si           | B       | Ti      | Ni        |
| 18.50 – 19.50                                 | < 0.050 | 9.75 – 10.50 | < 0.030 | < 0.050 | Remainder |

#### Unique Features:

- Extremely free and thin flowing for maximum capillarity.
- Self-fluxing properties.
- High degree of wetting & bonding.
- Strong, ductile & leak proof joints.

**Advantages:**

- Highly user friendly while dispensing.
- Precise, economical dosage even on small components.
- Pre-paste components can be stored for several hours prior to brazing operation.
- Clean binder with minimum smoke generation during furnace brazing.
- No post treatment or cleaning required after brazing

**Application / Dispensing:**

- Manually or automatically with pneumatical or mechanical dispensing units

**Physical Properties:**

|                   |  |
|-------------------|--|
| Color:            | Silver Grey                                  |
| Specific Gravity: | 8.92   |
| Density:          | 0.32 lb/in <sup>3</sup>                      |
| Shear strength    | 676 N/mm <sup>2</sup> (1.4006) At room temp. |

**Standard Packing :** 5 / 10 Kgs. Plastic Pails.