



AUFHAUSER Ni-68

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AUFHAUSER Ni-68 is a nickel-based brazing alloy containing tungsten, chromium and boron suited for use with cobalt, tungsten, and molybdenum-bearing base metals.

Nominal Composition, wt.%

Cr	Si	W	B	C	Fe	Ni
10.0	3.5	12.0	2.5	0.4	3.5	balance

Physical Properties

Solidus	1780°F (970°C)
Liquidus	2000°F (1095°C)
Recommended brazing range	2100 - 2200°F (1150 - 1205°C)

Brazing Characteristics

For furnace brazing, the brazing temperature range must be 2100 - 2200°F (1150 - 1205°C). For maximum flow, strength, and joint ductility, braze at the high end of the range. For minimum diffusion and erosion, braze at the low end of the range, and heat and cool the assembly as fast as possible without producing distortion. Atmospheres of pure-dry hydrogen, inert gases (-60°F [-51°C] dew point or better), or 10^{-4} vacuum are recommended.

Specifications

AWS A5.8 BNi-11

Available Forms

Powder, paste, sintered wire (rope), brazing tape