

## AIMTEK DF-3 Diffusion Brazing Powder

<b>Nominal Composition:</b>	<b>Ni – Balance</b> <b>Cr – 20%</b> <b>Co – 20%</b> <b>B – 3%</b> <b>Ta – 3%</b> <b>La – 0.05%</b>
<b>Melting Range:</b>	Solidus 1920°F (1050°C) Liquidus 2050°F (1121°C)
<b>Industry Specifications:</b>	EMS 54752, Type XVIII MS 2033
<b>Common Applications:</b>	Braze Repair of Ni and Co-based superalloy components; tight, deep, or wide cracks; Used with substrates where braze interface must be very similar to the parent material, such as Rene 80, IN738, IN959, IN625, MA754, and Mar-M-247
<b>Forms Available:</b>	Inert Gas Atomized Spherical Powder
<b>Particle Size Distribution:</b>	-106/+45 µm -45 µm
<b>Density:</b>	7.5 g/cm <sup>3</sup>
<b>Recommended Brazing Temperature</b>	2175-2225°F (1191-1218°C) Vacuum
<b>Recommended Diffusion Cycle</b>	1975°F (1080°C) @ 2-4 hrs.



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