

AIMTEK Mar-M-509B Diffusion Brazing Alloy

Nominal Composition:	Co – Balance Cr – 23.5% Ni – 10% W – 7% Ta – 3.5% B – 2.5% C – 0.6% Zr – 0.45% Ti – 0.25%
Melting Range:	Solidus 2065°F (1129°C) Liquidus 2130°F (1166°C)
Industry Specifications:	B50TF305 B50A989 MS1120 B-59
Common Applications:	Diffusion braze alloy for Cobalt based superalloy components in high temperature service conditions; crack repairs, restoration, and build-up when mixed with superalloy powder; excellent joint strength
Forms Available:	Inert Gas Atomized Spherical Powder, Paste, Pre-sintered Braze Preforms
Particle Size Distribution:	-106/+45 µm -45/+5 µm
Recommended Brazing Temperature:	2150-2300°F (1175-1260°C) Vacuum

