



# Nickel Chrome Brazing Pastes

## SPECIFICATIONS

Fusion Chromium Paste Filler Metals					
Fusion Number	Nominal Alloy Composition				
	Chromium	Nickel	Iron	Silicon	Phosphorus
A-250	23	66	--	6	5
A-251	23	51	15	6.5	4.5
A-252	29	40	18	7	6

### Fusion A-250

**Nominal Powder Mesh Size**  
140F mesh (AWS 140F grade)  
-106 +45  $\mu\text{m}$  (-140 +325 mesh)

**Melting Temperature**  
Solidus 993°C (1820°F)  
Liquidus 1010°C (1850°F)

**Brazing Temperature Range**  
Nominal Range 1066-1121°C  
(1950-2050°F)  
Optimum Range 1080-1107°C  
(1975-2025°F)

**Gap Size**  
12.5–51  $\mu\text{m}$  (0.0005-0.002 in.)  
free flowing

### Fusion A-251

**Nominal Powder Mesh Size**  
140F mesh (AWS 140F grade)  
-106 +45  $\mu\text{m}$  (-140 +325 mesh)

**Melting Temperature**  
Solidus 1027°C (1881°F)  
Liquidus 1055°C (1931°F)

**Brazing Temperature Range**  
Nominal Range 1104-1177°C  
(2020-2150°F)  
Optimum Range 1110-1150°C  
(2030-2130°F)

**Gap Size**  
12–75  $\mu\text{m}$  (0.0005-0.003 in.)

### Fusion A-252

**Nominal Powder Mesh Size**  
140F mesh (AWS 140F grade)  
-106 +45  $\mu\text{m}$  (-140 +325 mesh)

**Melting Temperature**  
Solidus 1074°C (1965°F)  
Liquidus 1104°C (2020°F)

**Brazing Temperature Range**  
Nominal Range 1176-1218°C  
(2150-2225°F)  
Optimum Range 1190-1204°C  
(2175-2200°F)

**Gap Size**  
12–75  $\mu\text{m}$  (0.0005-0.003 in.)



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