

Technical Data Sheet BrazeTec r1

Standard

DIN EN 1045 FH10
 AWS A5.31-92R -

Based on

boron compounds, fluorides

Technical Data

Working temperature range approx. 520 - 630 °C
 Colour colorless
 Density approx. 1.2 g/cm³ (20 °C)
 Flux residues corrosive; water-soluble
 Shelf life min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.
 Avoid rapid changes in temperature.

Packaging

Standard 5.0; 10 kg

Applications

Flux for brazing copper and conditionally copper alloys.
 BrazeTec r1 is suitable for all flame brazing, for induction brazing and resistance brazing procedures.
 Typical applications are found e.g. in the spectacle industry.
 Flux BrazeTec r1 is a low melting flux with short life time. Therefore it is especially suitable for short brazing times (< 10 sec).

Further Information

Additions of water may negatively alter the performance.
 Flux residues are corrosive and have to be removed by washing or by pickling.

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