### Technical Data Sheet BrazeTec r1

**Standard**
- DIN EN 1045
- AWS A5.31-92R

**Based on**
boron compounds, fluorides

### Technical Data

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

### 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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