**Technical Data Sheet BrazeTec d 21 Powder**

**Standard**
- DIN EN 1045: FH10
- AWS A5.31-92R: FB3-G

**Based on**
- boron compounds, fluorides

**Technical Data**
- **Working temperature range**: approx. 520 - 760 °C
- **Colour**: white
- **Density**: approx. 0.7 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.

**Packaging**
- **Standard**: 0.5; 1.0; 5.0; 10; 50 kg

**Applications**
- Flux powder for brazing steel, copper and copper alloys as well as nickel and nickel alloys.
- BrazeTec d 21 powder can be used for all flame and induction brazing processes.
- The flux adheres very well to the hot rod, but it can also be used as paste. In this case it should be mixed by stirring 1000 g of powder into 400 g of water.

**Further Information**
- Flux residues are corrosive and have to be removed by washing or by pickling.

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