

Technical Data Sheet BrazeTec h 280 Paste

Standard

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

Based on

boron compounds, fluorides, organic binder

Technical Data

Working temperature range	approx. 520 - 850°C
Colour	white
Density	approx. 1.3 g/cm ³ (20°C)
Viscosity	450 - 550 dPa s (Haake Viscotester 02, Sp.2, 20 ±2°C)
Cleaning agent	BrazeTec Cleaning Agent P
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. Stir well before use.

Packaging

Standard	1.0, 1.5 kg
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Applications

BrazeTec h 280 is a dosable flux paste which can be applied via a suitable applicator at the mouth of the gap. Normally it is used in mechanized brazing procedures. The paste should be homogenized prior to loading in the tank of the applicator.

The flux paste is suitable for brazing any steels, copper and copper alloys as well as nickel and nickel alloys.

The BrazeTec h 280 can be used for all flame and particular for induction brazing procedures. During brazing the organic binder must burn out completely.

Typical applications are found e.g. in the automotive and electrical industry.

Further Information

Stir well before use. Only homogeneously mixed paste will display constant and repeatable performance. Additions of water may negatively alter these parameters.

Please consider, that e.g. the loss of solvent may cause changes in the consistency of the flux paste.

Flux residues after brazing are corrosive and have to be removed e.g. by washing or by pickling.

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