Technical Data Sheet BrazeTec h 280 Paste

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

Based on
- boron compounds, fluorides, organic binder

Technical Data
- Working temperature range: approx. 520 - 850°C
- Colour: white
- Density: approx. 1.3 g/cm³ (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

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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