Technical Data Sheet BrazeTec h 285 Paste

Standard
DIN EN 1045  FH12
AWS A5.31-92R  FB3-H

Based on
boron compounds, fluorides, boron, organic binder

Technical Data
Working temperature range  approx. 520 - 910 °C
Colour  brown
Density  approx. 1.3 g/cm³ (20 °C)
Viscosity  60 - 90 Pas (Cone-plate, 150 µm; D= 0.5 1/s; 20 °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 285 is a dosable flux paste which can be applied via a suitable applicator on the part. 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 stainless steels, conditionally cemented carbides, copper and copper alloys as well as nickel and nickel alloys. BrazeTec h 285 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 tool (saw blades), electric and automotive industry.

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

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