

Technical Data Sheet BrazeTec h 285 Paste

Standard

DIN EN 1045
AWS A5.31-92R

FH12
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/cm ³ (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.

Details in product brochures or other advertisements about our products, equipment, plant and processes are based on our research and our experience in the field of applied engineering and are merely recommendations. It is not possible to infer any warranted qualities or warranted use from these details, unless they were expressly agreed as a warranted quality. We reserve the right to make technical modifications in the course of our product development.

The user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. This shall also apply to the protection of third party property rights as well as to applications and processes. The properties of samples and specimens are binding only if these have been expressly agreed to define the quality of the goods. Information on the quality and durability and other particulars are warranted only if these are agreed and designated as such. The specifications agreed with the user/purchaser in writing are relevant for the quality of the goods and if specifications have not been agreed in writing, the information contained in our technical data sheets, specifications or drawings.

Any additional or diverging agreements on the quality must be in writing. Any suitability of the product for the presupposed or customary use which supplements or diverges from the agreed quality is out of the question. Our General Conditions of Sale and Delivery shall apply; the current version is available at <http://www.saxonia-tm.de/en/TechnicalMaterials/agbs/>.