

Technical Data Sheet BrazeTec h 86 Paste

Standard

DIN EN 1045
AWS A5.31-92R

FH10
FB3-A

Based on

boron compounds, fluorides

Technical Data

Working temperature range	approx. 550 - 850 °C
Colour	white
Density	approx. 1.8 g/cm ³ (20 °C)
Viscosity	120 - 240 dPa s (Haake Viscotester 02, Sp.2, 20 ±2 °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. avoid rapid changes in temperature.

Packaging

Standard 3.0; 10 kg

Applications

Flux for brazing steel, copper and copper alloys as well as nickel and nickel alloys. BrazeTec h 86 paste is suitable for all flame brazing and for induction brazing procedures. The flux adheres well to vertical surfaces and hardly flows down. Typical applications are found e.g. in the automotive and electric industry (brazing of contacts). Flux BrazeTec h 86 is especially suitable for short brazing times (< 30 sec.).

Further Information

Stir well before use. Only homogeneously mixed paste will display constant and repeatable performance. Additions of water may negatively alter these parameters. Flux residues are corrosive and have to be removed by washing or by pickling.

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