# Technical Data Sheet BrazeTec h 900 Paste

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

Based on FH12
- FB3-H

Based on
- Boron compounds, Fluorides, Boron

## Technical Data

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Working temperature range</td>
<td>approx. 520 - 850 °C</td>
</tr>
<tr>
<td>Colour</td>
<td>brown</td>
</tr>
<tr>
<td>Density</td>
<td>approx. 1.3 g/cm³ (20 °C)</td>
</tr>
<tr>
<td>Viscosity</td>
<td>60 - 90 Pas (Cone-plate, 150 µm; D= 0.5 1/s; 20 °C)</td>
</tr>
<tr>
<td>Cleaning agent</td>
<td>BrazeTec Cleaning Agent P</td>
</tr>
<tr>
<td>Flux residues</td>
<td>corrosive, water-soluble</td>
</tr>
<tr>
<td>Shelf life</td>
<td>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.</td>
</tr>
</tbody>
</table>

## Packaging
- Standard 1.5 kg

## Applications
- BrazeTec h 900 Paste is a dosable flux paste which can be applied via a suitable applicator at the opening 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 stainless steels and cemented carbides.
- BrazeTec h 900 Paste 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 industry.

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

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