

TD-TM-BT-0910-E-04

## Standard

DIN EN 1045  
AWS A5.31-92R

Based on FH12  
FB3-F

## Based on

boron compounds, fluorides, boron, manganese

## Technical Data

Working temperature range	approx. 520 - 850 °C
Colour	brown
Density	approx. 0.6 g/cm <sup>3</sup>
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.

## Packaging

Standard 0.5 ; 1.0 kg

## Applications

Special flux powder for brazing metallic materials which are difficult to wet, like special cemented carbides, diamond segments with steel body and others.

The flux is normally used as paste. To get the paste we suggest to mix by stirring 100 g of powder into 35 g - 40 g of water. After stirring the flux develops a creamy paste, which becomes thicker in the first minutes. Therefore we recommend to stir again after 15 minutes and then to adjust the viscosity to the desired consistency if necessary. Do not generate more paste as you will use on the same day. BrazeTec h 90 powder can be used for all flame or induction brazing procedures. Typical applications are found e.g. in the tool industry.

## Further Information

Flux residues are corrosive and have to be removed by washing or by pickling.

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