Technical Data Sheet BrazeTech h 90 Pulver

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/cm³
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 poder 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 than to adjust the viscosity to the desired consistency if necessary. Do not generate more paste as you will use on the same day.
BrazeTech 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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