

Technical Data Sheet BrazeTec h Paste

Standard

DIN EN 1045
AWS A5.31-92R

FH10
FB3-A

Based on

boron compounds, fluorides

Technical Data

Working temperature range	approx. 550 - 970°C
Colour	white
Density	approx. 1.6 g/cm ³ (20°C)
Viscosity	120 - 200 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. Stir well before use.

Packaging

Standard 0.1; 0.5; 1.0; 10; 40 kg

Applications

BrazeTec h paste is a Flux for brazing steel, copper and copper alloys, nickel and nickel alloys as well as -under special conditions- on stainless steel.

The Brazing Flux BrazeTec h paste is suitable for all flame and induction brazing procedures. Typical application are found e.g. in the electrical industry, in the construction of vehicles and in the copper tube installation.

Further Information

Stir well before use. Only homogeneously mixed paste will display constant and repeatable performance. Additions of water may negatively alter these parameters. Please consider, that e.g. the loss of solvent may cause changes in the consistency of the flux paste.

Flux residues after brazing are corrosive and have to be removed e.g. by washing or by 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/>.