Technical Data Sheet BrazeTec h Paste

Standard
DIN EN 1045 FH10
AWS A5.31-92R FB3-A

Based on
boron compounds, fluorides

Technical Data
Working temperature range
approx. 550 - 970°C

Colour
white

Density
approx. 1.6 g/cm³ (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.

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