Technical Data Sheet BrazeTec l Paste

Standard
- DIN EN 1045: FH11
- AWS 5.21-92R: FB4-A

Based on
boron compounds, fluorides, chlorides

Technical Data
- Working temperature range: approx. 490 - 730 °C
- Colour: white
- Density: approx. 1.6 g/cm³ (20 °C)
- Viscosity: 40 - 80 dPa s (Haake Viscotester 02, Sp.1, 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: 1.0; 10; 40 kg

Applications
Flux for brazing steel, copper and copper alloys as well as nickel and nickel alloys. BrazeTec l paste allows to braze Al containing copper materials containing up to 10 % of aluminium. BrazeTec l paste is suitable for all flame and induction brazing procedures. Typical applications are found e.g. in the automotive and electric industry.

Further Information
Stir well before use. Only homogenizing mixed paste will display constant and repeatable performance. Additions of water may negatively alter these parameters. Flux residues are corrosive and have to be removed by washing or pickling.

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