

## Technical Data Sheet BrazeTec I Paste

### Standard

DIN EN 1045  
AWS 5.21-92R

FH11  
FB4-A

### Based on

boron compounds, fluorides, chlorides

### Technical Data

Working temperature range	approx. 490 - 730 °C
Colour	white
Density	approx. 1.6 g/cm <sup>3</sup> (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 I paste allows to braze Al containing copper materials containing up to 10 % of aluminium. BrazeTec I 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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