

## Technical Data Sheet BrazeTec s Paste

### Standard

DIN EN 1045  
AWS A5.31-92R

FH20  
FB3-D

### Based on

Boron Compounds, Fluorides

### Technical Data

Working temperature range	approx. 650 - 1050 °C
Colour	white to ocher colored
Density	approx. 1.5 g/cm <sup>3</sup> (20 °C)
Viscosity	30 - 80 dPa s (Haake Viscotester 02, Sp.2, 20 ±2 °C)
Flux residues	not corrosive; not 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 kg

### Applications

Flux for brazing cemented carbides, steel, copper and copper alloys, nickel and nickel alloys. BrazeTec s paste is suitable for all flame brazing and for induction brazing procedures. Typical applications are found e.g. in the automotive and tool industry.

### Further Information

Stir well before use. Only homogeneously mixed paste will display constant and repeatable performance. Additions of water may negatively alter these parameters. Flux residues are not corrosive and can be removed mechanical or by pickling.

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