Technical Data Sheet BrazeTec spezial h Paste

Standard
DIN EN 1045
AWS A5.31-92R
FH12
FB3-C

Based on
boron compounds, fluorides, boron

Technical Data
Working temperature range
approx. 520 - 1030°C

Colour
brown

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 spezial h paste is a Flux for brazing stainless steel and cemented carbides.
The Brazing Flux BrazeTec spezial h paste is suitable for all flame and induction brazing procedures.
Typical applications are found e.g. in the 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.
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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