

Technical Data Sheet BrazeTec special s Paste

Standard

DIN EN 1045
AWS A5.31-92R

FH20
FB3-D

Based on

Boron compounds, Fluorides, Boron

Technical Data

Working temperature range	approx. 650 - 1050 °C
Colour	brown
Density	approx. 1.5 g/cm ³ (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 0.1; 1.0; 10 kg

Applications

Flux for brazing cemented carbides, stainless steels, mild steels, nickel and nickel alloys. BrazeTec special s 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.

Flux residues are not corrosive and can be removed mechanical or by pickling.

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