Technical Data Sheet BrazeTec spezial s Paste

Standard
DIN EN 1045  FH20
AWS A5.31-92R  FB3-D

Based on
Boron compounds, Fluorides, Boron

Technical Data
Working temperature range  approx. 650 - 1050 °C
Colour  brown
Density  approx. 1.5 g/cm³ (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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