TD-STM-BT-E-0922-00

Technical Data Sheet BrazeTec h 285 Paste

Standard

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

Based on boron compounds, fluorides, boron, organic binder

Technical Data

Working temperature range	approx. 520 - 910°C
Colour	brown
Density	approx. 1.3 g/cm³ (20°C)
Viscosity	60 - 90 dPa s (Cone-plate, 150 µm; D= 0.5 1/s; 20 °C)
Cleaning agent	BrazeTec Cleaning Agent P
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; 1.5 kg

Applications

BrazeTec h 285 is a dosable flux paste which can be applied via a suitable applicator on the part. Normally it is used in mechanized brazing procedures. The paste should be homogenized prior to loading in the tank of the applicator.
The flux paste is suitable for brazing stainless steels, conditionally cemented carbides, copper and copper alloys as well as nickel and nickel alloys. BrazeTec h 285 can be used for all flame and particular for induction brazing procedures. During brazing the organic binder must burn out completely.
Typical applications are found e.g. in the tool (saw blades), electric and automotive industry.

Further Information

Additions of water may negatively alter these parameters.
Flux residues are corrosive and have to be removed by washing or by pickling.

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