

## Technical Data Sheet BrazeTec h 80 Paste

### Standard

DIN EN 1045  
AWS A5.31-92R

FH10  
FB3-A

### Based on

boron compounds, fluorides

### Technical Data

Working temperature range approx. 550 - 850°C  
Colour white  
Density approx. 1.6 g/cm<sup>3</sup> (20°C)  
Viscosity 80 - 160 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.

### Packaging

Standard 0.1; 1.0; 1.5; 3.0; 10; 40 kg

### Applications

Flux for brazing cemented carbides and alloyed steels but also mild steel, copper and copper alloys as well as nickel and nickel alloys.

BrazeTec h 80 paste is suitable for all flame brazing and for induction brazing procedures.

Typical applications are found e.g. in the tool industry (cemented carbides, diamond segments), automotive and electric industry (contacts).

Flux BrazeTec h 80 is especially suitable for short brazing times (< 30 sec.)

### 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 corrosive and have to be removed by washing or by pickling.

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