

Technical Data Sheet BrazeTec h 900 Paste

StandardDIN EN 1045
AWS A5.31-92RBased on FH12
FB3-H**Based on**

Boron compounds, Fluorides, Boron

Technical DataWorking temperature range
Colour
Density
Viscosity
Flux residues
Shelf lifeapprox. 520 - 850°C
brown
approx. 1.3 g/cm³ (20°C)
60 - 90 dPa s (Cone-plate, 150 µm; D= 0.5 1/s; 20 °C)
corrosive, water-soluble
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

1.5 kg

Applications

BrazeTec h 900 Paste is a dosable flux paste which can be applied via a suitable applicator at the opening of the gap. 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 and cemented carbides.

BrazeTec h 900 Paste 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 industry.

Further Information

Additions of solvent may negatively alter the performance.

Flux residues are corrosive and have to be removed by washing or by pickling.

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