

Technical Data Sheet BrazeTec h Paste

Standard

DIN EN 1045
AWS A5.31-92R

FH10
FB3-A

Based on

boron compounds, fluorides

Technical Data

Working temperature range approx. 550 - 970°C
Colour white
Density approx. 1.6 g/cm³ (20°C)
Viscosity 120 - 200 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.
Stir well before use.

Packaging

Standard 0.1; 0.5; 1.0; 10; 40 kg

Applications

BrazeTec h paste is a Flux for brazing steel, copper and copper alloys, nickel and nickel alloys as well as - under special conditions- on stainless steel.

The Brazing Flux BrazeTec h paste is suitable for all flame and induction brazing procedures. Typical application are found e.g. in the electrical industry, in the construction of vehicles and in the copper tube installation.

Further Information

Stir well before use. Only homogeneously mixed paste will display constant and repeatable performance. Additions of water may negatively alter these parameters.

Please consider, that e.g. the loss of solvent may cause changes in the consistency of the flux paste. Flux residues after brazing are corrosive and have to be removed e.g. by washing or by pickling.

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