

Technical Data Sheet BrazeTec I Paste

Standard

DIN EN 1045
AWS 5.21-92R

FH11
FB4-A

Based on

boron compounds, fluorides, chlorides

Technical data

Working temperature range
Colour
Density
Viscosity
Flux residues
Shelf life

approx. 490 - 730 °C
white
approx. 1.6 g/cm³ (20 °C)
40 - 80 dPa s (Haake Viscotester 02, Sp.1, 20 ±2 °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

1.0; 10; 40 kg

Applications

Flux for brazing steel, copper and copper alloys as well as nickel and nickel alloys.
BrazeTec I paste allows to braze Al containing copper materials containing up to 10 % of aluminium.
BrazeTec I paste is suitable for all flame and induction brazing procedures.
Typical applications are found e.g. in the automotive and electric industry.

Further Information

Stir well before use. Only homogenizing 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 pickling.

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