

## Technical Data Sheet BrazeTec spezial h Paste

### Standard

DIN EN 1045  
AWS A5.31-92R

FH12  
FB3-C

### Based on

boron compounds, fluorides, boron

### Technical Data

Working temperature range approx. 520 - 1030°C  
Colour brown  
Density approx. 1.6 g/cm<sup>3</sup> (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 spezial h paste is a Flux for brazing stainless steel and cemented carbides.  
The Brazing Flux BrazeTec spezial h paste is suitable for all flame and induction brazing procedures.  
Typical applications are found e.g. in the tool industry.

### 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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