

Technical Data Sheet BrazeTec D 21 Powder

StandardDIN EN 1045
AWS A5.31-92RFH10
FB3-G**Based on**

boron compounds, fluorides

Technical Data

Working temperature range	approx. 520 - 760 °C
Colour	white
Density	approx. 0,7 g/cm ³ (20 °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.

Packaging

Standard 0.5; 1.0; 5.0; 10; 50 kg

Applications

Flux powder for brazing steel, copper and copper alloys as well as nickel and nickel alloys. BrazeTec D 21 powder can be used for all flame and induction brazing processes.

The flux adheres very well to the hot rod, but it can also be used as paste. In this case it should be mixed by stirring 1000 g of powder into 400 g of water.

Further Information

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

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