

## Technical Data Sheet BrazeTec H Paste

**Standard**DIN EN 1045  
AWS A5.31-92RFH10  
FB3-A**Based on**

boron compounds, fluorides

**Technical Data**

Working temperature range approx. 550 - 970°C  
Colour white  
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 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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