

Technical Data Sheet BrazeTec R 1 Paste

StandardDIN EN 1045
AWS A5.31-92R

FH10

Based on

boron compounds, fluorides

Technical Data

Working temperature range	approx. 520 - 630°C
Colour	colorless
Density	approx. 1.2 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. Avoid rapid changes in temperature. Stir well before use.

Packaging

Standard 5.0, 10 kg

Applications

BrazeTec R1 is a flux for brazing copper and conditionally copper alloys.
BrazeTec R1 is suitable for all flame brazing, for induction brazing and resistance brazing procedures. Typical applications are found e.g. in the spectacle industry.
Flux BrazeTec R1 is a low melting flux with short life time. Therefore, it is especially suitable for short brazing times (< 10 sec).

Further Information

Additions of water may negatively alter these parameters.

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

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