



Technical Data Sheet BrazeTec s Paste



TD BT 0912 E.01

Inhalt Standard

Type FH21 according DIN EN 1045

Composition

alkaline borates; potassiumhexafluoroaluminate;
silicondioxid; water

Technical Data

Working temperature range	750 - app. 1100°C
Colour	white to ocher coloured
Density	app. 1,5 g/cm ³
Viscosity	30 - 80 dPas (Haake Viskotester VT02; 18 - 22°C)
Flux residues	not corrosive; not water-soluble
Shelf life	min. 6 months in the original locked container storage temperature +5 to +30°C avoid rapid changes in temperature

Packing

1,0 kg ; 10 kg

Application

Flux for brazing cemented carbides, steel, nickel and nickel alloys.
BrazeTec s paste is suitable for all flame brazing and for induction brazing procedures.
Typical applications are found e.g. in the automotive and tool industry.

Note for the user

Flux residues are not corrosive and it is not necessary to remove them.

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