

Technical Data Sheet BrazeTec h 900 Paste

Standard

DIN EN 1045
AWS A5.31-92R

Based on FH12
FB3-H

Based on

Boron compounds, Fluorides, Boron

Technical Data

Working temperature range	approx. 520 - 850 °C
Colour	brown
Density	approx. 1.3 g/cm ³ (20 °C)
Viscosity	60 - 90 Pas (Cone-plate, 150 µm; D= 0.5 1/s; 20 °C)
Cleaning agent	BrazeTec Cleaning Agent P
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 1.5 kg

Applications

BrazeTec h 900 Paste is a dosable flux paste which can be applied via a suitable applicator at the opening of the gap. Normally it is used in mechanized brazing procedures. The paste should be homogenized prior to loading in the tank of the applicator.

The flux paste is suitable for brazing stainless steels and cemented carbides.

BrazeTec h 900 Paste can be used for all flame and particular for induction brazing procedures.

During brazing the organic binder must burn out completely.

Typical applications are found e.g. in the tool industry.

Further Information

Additions of solvent may negatively alter the performance.

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

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