



Brazing Flux BrazeTec D99

TD EN D99 REV.2

Composition and technical data:

Composition (% in weight)	Potassium fluorate 1-10 Potassium tetrafluoroborate 40-60
Colour	White
Working temperature (°C)	550-800
Density (g/cm ³)	0,5
Chemical characteristics	Hygroscopic
PH	8 (10 g/l in water at 20 °C)
Solubility	100 g/l (water at 20°C)
State of product	Powder
Residues	Residues are corrosive and have to be removed with water and mechanical rubbing
Standard DIN EN 1045	FH 10
Shelf life	Min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

Applications

Electrical industry, automotive

Operating conditions

Flux for brazing process. Excellent for removing surface oxides. Used for joining steel, copper and copper alloys, as well as nickel and nickel alloys.

Recommended alloys

BrazeTec 5600,5507,4576, 4404, 4076, 3876, 3476, 3375, 3076, 3075, 2576, 2500, 2009, 1875, 1204, 503

Heat source

Flame, induction heating

Notes

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