



Brazing Flux BrazeTec H SPEZIAL

TD EN H SPEZIAL REV.2

Composition and technical data:

Composition (% in weight)	Potassium Hydroxy Fluoroborate 67-73 Water 27-33
Colour	Brown
Working temperature (°C)	520-1030
Density (g/cm ³)	1,4
Chemical characteristics	-
PH	5,5 (10 g/l in water at 20 °C)
Solubility	500 g/l (in water at 20°C)
State of product	Paste
Residues	Residues are corrosive and have to be removed with water and mechanical rubbing
Standard DIN EN 1045	FH12
Shelf life	Min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

Applications

Tool industry

Operating conditions

Flux for brazing process. Excellent for removing surface oxides. Used for brazing cemented carbides, steel and stainless steel.

Recommended alloys

BrazeTec 7200, 6488, 6009, 5662, 5081, 4900, 4911, 4900A, 4085, 2700, 21/80, 21/68, 49Cu,49Cu13,49/NiN,64/Cu, 49Cuplus

Heat source

Flame, induction heating

Notes

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