



Brazing Flux BrazeTec H 28 PASTE

TD EN H PASTE REV.2

Composition and technical data:

Composition (% in weight)	Potassium Tetrafluoroborate 30-40 Amorphous silica 1-5 Mixture of borates mixed with water rest
Colour	White
Working temperature (°C)	580-940
Density (g/cm ³)	1,7
Chemical characteristics	Hygroscopic
PH	5,5 (10 g/l in water at 20 °C)
Solubility	300 g/l (in water at 20°C)
State of product	Paste, 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

Refrigeration, air conditioning and electrical industry, automotive, precision metal parts, fashion accessories, plumbing technology

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. It does not become liquid during heating up to 100°C, so it can be used for machine brazing operations on inclined or vertically positioned work pieces.

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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