



Brazing Flux BrazeTec H 80 PASTE

TD EN H 80 REV.2

Composition and technical data:

Composition (% in weight)	Potassium hydroxy fluoroborate 10-20 Potassium tetrafluoroborate 60-80
Colour	White
Working temperature (°C)	550-850
Density (g/cm ³)	1,5
Chemical characteristics	Hygroscopic
PH	6,2 (10 g/l at 20 °C)
Solubility	350 g/l (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	FH 10
Shelf life	Min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

Applications

Tool industry, automotive

Operating conditions

Flux for brazing process. Excellent for removing surface oxides. Used for brazing metallic materials which are difficult to wet, such as cemented carbides, copper, copper alloys, as well as nickel, nickel alloys and mild steels. Suitable for short brazing process < 30 sec.

Recommended alloys

BrazeTec 5600,5507,4576, 4404, 4076, 3876, 3476, 3375, 3076, 3075, 2576, 2500, 2009, 1875, 1204, 503, 7200, 6488, 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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