



Brazing Flux BrazeTec H 90

TD EN H 90 REV.2

Composition and technical data:

Composition (% in weight)	Boron compounds, fluorides, manganese
Colour	Brown
Working temperature (°C)	520-850
Density (g/cm ³)	0,6
Chemical characteristics	-
PH	-
Solubility	-
State of product	Powder
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 metallic materials which are difficult to wet, such as cemented carbides, diamond segments with steel body.

Recommended alloys

BrazeTec 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

Powder, flux is normally used as paste. To get the paste we suggest to mix 100 g of powder into 35 g - 40 g of water. After stirring, the flux develops into a creamy paste. If necessary, we recommend to stir again after 15 minutes to obtain the viscosity and consistency desired. Do not generate more paste than needed that day.

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