



## Brazing Flux BrazeTec H PASTE

TD EN H REV.2

### Composition and technical data:

|                              |  |
|------------------------------|--|
| Composition (% in weight)    | Potassium hydroxy fluoroborate 67-73<br>Water 27-33  |
| Colour                       | White  |
| Working temperature (°C)     | 550-970  |
| Density (g/cm <sup>3</sup> ) | 1,4  |
| Chemical characteristics     | Hygroscopic  |
| PH                           | 5,4 (10 g/l in water at 20°C)  |
| Solubility                   | 500 g/l (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 (in certain conditions also stainless steel), copper and copper alloys, as well as nickel and nickel alloys. BrazeTec H paste meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German Association of Gas and Water).

It is approved and registered by DVGW (DV-0101AU2227) and has been awarded by the Gütegemeinschaft Kupferrohr e.V. (The coppertube Manufactures Quality Association).

### 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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