



Brazing Flux BrazeTec S

TD EN S REV.2

Composition and technical data:

Composition (% in weight)	Potassium aluminum fluoride 9-11 mixture 45-50	Silica 7-11	Borates
Colour	White		
Working temperature (°C)	650-1050		
Density (g/cm ³)	1,5		
Chemical characteristics	-		
PH	8 (10 g/l in water at 20 °C)		
Solubility	180 g/l in water at 20°C		
State of product	Paste		
Residues	Non-corrosive residues		
Standard DIN EN 1045	FH20		
Shelf life	Min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.		

Applications

Automotive, tool industry, mechanical engineering

Operating conditions

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

Recommended alloys

Cu/NiN,21/80, 21/68,

Heat source

Flame, induction heating

Notes

Residues can be removed with water and mechanical rubbing

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