



## Technical Data Sheet BrazeTec I Paste



TD BT 0923 E.02

### Inhalt

#### Standard

DIN EN 1045

FH11

#### Based on

boron compounds, fluorides, chlorides

#### Technical Data

Working temperature range

approx. 550 - 800 °C

Colour

white

Density

approx. 1,6 g/cm<sup>3</sup> (20 °C)

Viscosity

40 - 80 dPa s (Haake Viscotester 02, Sp.1, 20 ±2 °C)

Flux residues

corrosive, water-soluble

Shelf life

min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C. avoid rapid changes in temperature. stir well before use.

#### Packaging

Standard

1,0; 10; 40 kg

#### Applications

Flux for brazing steel, copper and copper alloys as well as nickel and nickel alloys.

BrazeTec I paste allows to braze Al containing copper materials containing up to 10 % of aluminium.

BrazeTec I paste is suitable for all flame and induction brazing procedures.

Typical applications are found e.g. in the automotive and electric industry.

#### Further Information

Flux residues are corrosive and have to be removed by washing or pickling.

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