



## Technical Data Sheet BrazeTec h 285 Paste



TD BT 0922 E.01

### Inhalt

#### Standard

DIN EN 1045

FH12

#### Based on

boron compounds, fluorides, boron, organic binder

#### Technical Data

Working temperature range

approx. 550 - 800 °C

Colour

brown

Density

approx. 1,3 g/cm<sup>3</sup> (20 °C)

Viscosity

450 - 550 dPa s (Haake Viscotester 02, Sp.2, 20 ±2 °C)

Cleaning agent

BrazeTec Cleaning Agent P

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; 1,5 kg

#### Applications

BrazeTec h 285 is a dosable flux paste which can be applied via a suitable applicator at the mouth of the gap. Normally it is used in mechanised brazing procedures. The paste should be homogenised prior to loading in the tank of the applicator.

The flux paste is suitable for brazing stainless steels, conditionally cemented carbides, copper and copper alloys as well as nickel and nickel alloys. BrazeTec h 285 can be used for all flame and particular for induction brazing procedures. During brazing the organic binder must burn out completely.

Typical applications are found e.g. in the tool industry.

#### Further Information

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

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