



Technical Data Sheet BrazeTec h 90 Powder



TD BT 0910 E.01

Inhalt

Standard

DIN EN 1045

Based on FH12

Based on

boron compounds, fluorides, boron, manganese

Technical Data

Working temperature range

approx. 550 - 850 °C

Colour

brown

Density

approx. 0,6 g/cm³

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.

Packaging

Standard

0,5 ; 1,0 kg

Applications

Special flux for brazing metallic materials which are difficult to wet, like special cemented carbides, diamond segments with steel body and others.

The flux is normally used as paste. To get the paste we suggest to mix by stirring 100 g of powder into 35 g - 40 g of water. After stirring the flux develops a creamy paste, which becomes thicker in the first minutes. Therefore we recommend to stir again after 15 minutes and than to adjust the viscosity to the desired consistency if necessary. Do not generate more paste as you will use on the same day.

BrazeTec h 90 powder can be used for all flame or induction brazing procedures.

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

Further Information

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

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