

Technical Data Sheet BrazeTec h 28 Paste

Standard

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| DIN EN 1045 | FH10 |
| AWS A5.31-92R | FB3-A |

Based on

boron compounds, fluorides

Technical Data

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|---------------------------|---|
| Working temperature range | approx. 580 - 940 °C |
| Colour | white |
| Density | approx. 1.7 g/cm ³ (20 °C) |
| Viscosity | 50 - 150 dPa s (Haake Viscotester 02, Sp.2, 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. |

Packaging

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| Standard | 1.0; 10; 40 kg |
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Applications

Flux for brazing steel, copper and copper alloys as well as nickel and nickel alloys. BrazeTec h 28 paste is suitable for all flame brazing and for induction brazing procedures. Typical applications are found e.g. in the automotive and electric industry.

Further Information

Stir well before use. Only homogeneously mixed paste will display constant and repeatable performance. Additions of water may negatively alter these parameters. Flux residues are corrosive and have to be removed by washing or by pickling.

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