



Brazing is BrazeTec 

## Brazing Flux BrazeTec 32/80

### Composition and technical data:

Composition (% in weight)	Fluorides mixture
Colour	White
Working temperature (°C)	570-660
Density (g/cm <sup>3</sup> )	0,5
Chemical characteristics	-
PH	-
Solubility	-
State of product	Paste, powder that should be mixed with water
Residues	Non-corrosive and water-insoluble residues
Standard ISO 18496	FL20 A
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

### Applications

Air conditioning industry, automotive, heating system

### Operating conditions

Flux for brazing aluminium and low-joined aluminium alloys with melting temperature higher than 630°C. Used for joining stainless steel-aluminium. Brazing process is limited for aluminium alloys with Mg content > 0,6%.

### Recommended alloys

Alubraze L88/12

### Heat source

Flame, induction heating, furnace. For brazing under protective atmosphere the flux powder has to be mixed with water to a suspension from 5% to 25% to be sprayed onto the part (e.g. radiator brazing) or applied as a brushable paste (e.g. fryers). For plate heat exchangers are used brushable pastes.

Mixing ratio: powder : water = 1 : 1 to 1 : 1,5 or powder : water : alcohol = 3 : 3 : 1.

### Notes

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