



Brazing is BrazeTec 

## Brazing Flux BrazeTec H 285

### Composition and technical data:

Composition (% in weight)	Potassium Tetrafluoroborate 20-30 Distillate 20-30 Potassium Hydroxide 0,5-2
Colour	Brown
Working temperature (°C)	520-910
Density (g/cm <sup>3</sup> )	1,1
Chemical characteristics	Partially water soluble
PH	-
Solubility	Partially water soluble
State of product	Paste
Residues	Residues are corrosive and have to be removed with water and mechanical rubbing
Standard ISO 18496	FH12 B
Shelf life	Min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

### Applications

Tool and electrical industry, automotive

### Operating conditions

Flux for brazing process. Excellent for removing surface oxides. Used for brazing metallic materials which are difficult to wet, such as cemented carbides, copper, copper alloys, as well as nickel, nickel alloys and stainless steel. Suitable for dispenser application in automated brazing process.

### Recommended alloys

BrazeTec 7200, 6488, 6009, 5662, 5081, 4900, 4911, 4900A, 4085, 2700, 21/80, 21/68, 49Cu, 49Cu13, 49/NiN, 64/Cu, 49Cuplus

### Heat source

Flame, induction heating

### Notes

-

The information reported in this document about our products and equipment as well as our systems and procedures are based on our research and our experience in the field of applied engineering and are merely recommendations. Italbras S.p.A. cannot foresee all circumstances in which these information and our products will be used, therefore the user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. Italbras S.p.A. declines any liability for any loss, damage or injury howsoever arising (including any claim brought by third parties) as a result of the use of such information. Each warranty of suitability of our products and their use within the production processes of the user, must be agreed in written form. We reserve the right to make technical modifications to this document in the course of our product development.

### Italbras S.p.A.

Strada del Balsego, 6 – 36100 Vicenza (I)  
[info@italbras.it](mailto:info@italbras.it) - [www.italbras.it](http://www.italbras.it) -  
 Tel. +39 0444.3475-00 / Fax +39 0444.3475-01