



Brazing is BrazeTec 

Brazing Flux BrazeTec H 28 Paste

Composition and technical data:

Composition (% in weight)	Potassium Tetrafluoroborate 30-40 Amorphus silica 1-5 Mixture of borates mixed with water rest
Colour	White
Working temperature (°C)	580-940
Density (g/cm ³)	1,7
Chemical characteristics	Hygroscopic
PH	5,5 (10 g/l in water at 20 °C)
Solubility	300 g/l (in water at 20°C)
State of product	Paste
Residues	Residues are corrosive and have to be removed with water and mechanical rubbing
Standard ISO 18496	FH10 B
Shelf life	Min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

Applications

Refrigeration, air conditioning and electrical industry, automotive, precision metal parts, fashion accessories, plumbing technology

Operating conditions

Flux for brazing process. Excellent for removing surface oxides. Used for joining steel, copper and copper alloys, as well as nickel and nickel alloys. Used for brazing operations on inclined or vertically positioned work pieces.

Recommended alloys

BrazeTec 5600,5507,4576, 4404, 4076, 3876, 3476, 3375, 3076, 3075, 2576, 2500, 2009, 1875, 1204, 503

Heat source

Flame, induction heating

Notes

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