



Brazing is BrazeTec 

## Brazing Flux BrazeTec H 80

### Composition and technical data:

|                              |  |
|------------------------------|--|
| Composition (% in weight)    | Potassium hydroxy fluoroborate 10-20<br>Potassium tetrafluoroborate 60-80                              |
| Colour                       | White  |
| Working temperature (°C)     | 550-850  |
| Density (g/cm <sup>3</sup> ) | 1,5  |
| Chemical characteristics     | Hygroscopic  |
| PH                           | 6,2 (10 g/l at 20 °C)  |
| Solubility                   | 350 g/l (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

Tool 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 mild steels. Suitable for short brazing process < 30 sec.

### Recommended alloys

BrazeTec 5600, 5507, 4576, 4404, 4076, 3876, 3476, 3375, 3076, 3075, 2576, 2500, 2009, 1875, 1204, 503, 7200, 6488, 5662, 5081, 4900, 4911, 4900A, 4085, 2700, 21/80, 21/68, 49Cu, 49Cu13, 49/NiN, 64/Cu, 49Cuplus

### Heat source

Flame, induction heating

### Notes

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