



Brazing is BrazeTec 

## Brazing Flux BrazeTec H 900

### Composition and technical data:

Composition (% in weight)	Boron compounds, fluorides, boron
Colour	Brown
Working temperature (°C)	520-850
Density (g/cm <sup>3</sup> )	1,3 a 20° C
Chemical characteristics	-
PH	-
Solubility	-
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 industry

### 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, diamond segments with steel body.

### Recommended alloys

BrazeTec 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

Dosable paste

Viscosity 60-90 Pas (Cone-plate, 150 µm, D=0,5 1/s; 20°C)

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