



Brazing is BrazeTec 

Brazing Flux BrazeTec L Paste

Composition and technical data:

Composition (% in weight)	Potassium Tetrafluoroborate 15-25 Lithium Chloride 1-5 Tripotassium Hexafluoride Aluminated 1-10 Zinc Chloride 1-10
Colour	White
Working temperature (°C)	490-730
Density (g/cm ³)	1,6
Chemical characteristics	-
PH	8 (10 g/l in water at 20 °C)
Solubility	180 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	FH11 B
Shelf life	Min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

Applications

Automotive, electrical industry

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. Suitable for brazing copper alloys with Al content < 10 %.

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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