



Brazing is BrazeTec 

Brazing Flux BrazeTec S

Composition and technical data:

Composition (% in weight)	Potassium aluminum fluoride 9-11 Borates mixture 45-50 Silica 7-11
Colour	White
Working temperature (°C)	650-1050
Density (g/cm ³)	1,5
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	Non-corrosive residues
Standard ISO 18496	FH20 B
Shelf life	Min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

Applications

Automotive, tool industry, mechanical engineering

Operating conditions

Flux for brazing process. Excellent for removing surface oxides. Used for brazing cemented carbides, steel, nickel and nickel alloys.

Recommended alloys

Cu/NiN, 21/80, 21/68,

Heat source

Flame, induction heating

Notes

Residues can be removed with water and mechanical rubbing

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