BRAZETEC®

BRAZETEC
Brazing Fluxes

MEMBER OF
Saxonia Group

/ BRAZETEC Brazing Fluxes

The choice of flux is made in accordance with the working temperature of the brazing alloy and the base materials. The working temperature or melting range of the brazing alloy should be within the effective temperature range of the flux. The effective temperature ranges specified are derived from our extensive research. Additional fluxes for special applications are available upon request. Customised containers are also possible according to customers needs. BRAZETEC flux types FH10, FH11 and FH12 are traditionally free of boric acid.

Name	ISO 18496	Effective Temperature Range [1]	Available Forms			Notes on Application
		in °C	Paste	Dispensable Paste	Powder	
BrazeTec h	FH 10	550 – 970	•	–	•	universal flux for heavy metals
BrazeTec h 28	FH 10	580 – 940	•	–	–	flux for automated brazing
BrazeTec h 80	FH 10	550 – 850	•	–	–	flux for brazing of larger areas
BrazeTec h 86	FH 10	550 – 850	•	–	–	flux for brazing of larger areas
BrazeTec h 280	FH 10	520 – 850	–	•	–	flux for automated brazing
BrazeTec r 1	FH 10	520 – 630	•	–	–	flux for non-ferrous metals for special tools
BrazeTec d 21	FH 10	520 – 760	–	–	•	powder-type flux for steel and non-ferrous metals, powder clings to hot rods
BrazeTec d	FH 10	550 – 850	–	–	•	flux for any steel type, non-ferrous metals for special
BrazeTec f	FH 10	610 – 1025	•	–	–	prevention of red staining in copper alloys
BrazeTec l	FH 11	490 – 730	•	–	–	flux for heavy metals with up to 10% aluminium
BrazeTec lpb	FH 11	490 – 730	•	–	–	flux for aluminium-containing heavy metals up to 10 % aluminium; special materials that are difficult to wet, e.g. materials containing lead
BrazeTec spezial h	FH 12	520 – 1.030	•	–	•	flux for stainless and scale resistant steels, carbides, special materials
BrazeTec h 90	FH 12	520 – 850	–	–	•	flux for special carbides
BrazeTec h 285	FH 12	520 – 910	–	•	–	flux for automated brazing, also suitable for carbide brazing
BrazeTec h 900	FH 12	520 – 820	–	•	–	flux for machine brazing for special carbides
BrazeTec s	FH 20	650 – 1.050	•	–	•	flux, also for high-alloy-steel, Ni-alloys, carbides. non-corrosive flux residues
BrazeTec spezial s	FH 20	650 – 1.050	•	–	–	flux for non-rusting steels, super alloys, carbides, special metals. non-corrosive flux residues
BrazeTec rs-a	FH 21	800 – 1100	•	–	–	flux for copper and copper alloys, steels, nickel alloys; non-corrosive flux residues
BrazeTec ms Pulver	FH 21	700 – 1100	–	–	•	flux for copper and copper alloys, steels, nickel alloys; non-corrosive flux residues
BrazeTec t	-	600 – 980	•	–	–	low-viscosity flux; for special applications such as resistance brazing

[1] On S 235 in furnace and air. Suitable brazing filler metal must wet and flux shouldn't be burnt completely.

/ BRAZETEC Anti Flux

BrazeTec Anti-Flux ASV prevents the wetting of the brazing alloy on surfaces that should not be wet and thereby permits selective and precise brazing.

Name	Delivery Form	Brazing Procedure	Brazing Atmosphere
BrazeTec Antiflux ASV	paste	soft soldering, brazing and high temperature brazing	air, protective gas, vacuum

BRAZETEC GmbH / Konrad-Zuse-Straße 13 / 63755 Alzenau / Germany
Tel.: +49 6023 5071-0 / info@brazetec.de / www.brazetec.de