

Technical data

Brazing flux

Easy-flo™ Aluminium bronze grade flux paste

Product description

Easy-flo™ Aluminium Bronze Grade Flux Paste is specially formulated for use with silver brazing filler metals on aluminium bronze and other copper alloys containing more than 2% aluminium, but less than 10% aluminium. It is able to dissolve aluminium oxide where other fluxes would fail. It has a working range of 550-775 °C and is recommended for use with alloys melting below 725 °C (such as several of the Silver-flo™ and Easy-flo™ filler metals).

Conforms to: EN 1045: FH11

Melting range: 550-775 °C

Directions for use

Before use stir flux paste well to ensure a consistent mixture throughout. Flux paste should be brushed onto the joint surfaces before assembly. Further flux should then be applied externally either side of the joint mouth.

It is good practice to mechanically clean and degrease the joint surface before applying flux. Heat slowly and evenly to the brazing temperature, without local overheating. Use the flux as a temperature guide - it will become clear or opaque as brazing temperature is approached. If blackening of the flux occurs this is often a sign of insufficient flux, overheating or flux exhaustion.

Conditions for use

Flux residue removal: The flux residues of this product, left after completion of the brazing operation, are corrosive and should be removed. They can be readily removed by soaking in hot water at a temperature >40 °C for between 15 and 30 minutes. Any remaining residues can then be brushed off in running water.

Product availability

1 kg Plastic Pots

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