

Technical data

Brazing flux

Easy-flo™ No. 25 Liquid flux

Product description

Johnson Matthey Easy-flo™ No. 25 Liquid Flux is a liquid brazing flux suitable for use with silver brazing filler metals. It has a working range of 600-850 °C and is suitable for use with filler metals melting below 800 °C (such as Silver-flo™, Easy-flo™ and Argo-braze™ alloys). Easy-flo™ No. 25 Liquid Flux formerly sold as Liquid Flux No. 25.

Easy-flo™ No. 25 Liquid Flux can be used for jewellery parts or any other application that requires the use of a liquid flux or where limited fluxing is required. This flux has also been used for brazing in furnaces that have poor atmospheres, where a flux is required to achieve filler metal wetting.

It can be used on precious metals as well as all of the common engineering materials (copper, brass, mild steel and stainless steel, but not aluminium). JM special purpose fluxes are required when brazing aluminium bronze, certain grades of stainless steel, tungsten, molybdenum and tungsten carbide or where protracted heating is involved.

Conforms to: AWS FB3E, EN 1045: FH10

Melting range: 600 - 850 °C

Directions for use

Easy-flo™ No. 25 Liquid Flux is concentrated and may be used in this form or diluted to a desired strength by adding water. It should be brushed onto the joint surfaces before assembly. Further flux should then be applied externally either side of the joint mouth. It is possible to apply this flux with automatic dispensing equipment.

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. 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 left after completion of the brazing operation are corrosive and should be removed. The residues of Easy-flo™ No. 25 Liquid Flux can easily be removed by soaking in hot water > 40°C for between 15 and 30 minutes. Any remaining residues can then be brushed off in running water.

Product availability

Flux residue removal:

1 litre containers

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