

Technical data

Brazing flux

Easy-flo™ Low temperature grade flux paste

Product description

Easy-flo™ Low Temperature Grade Flux paste is a brazing flux suitable for use with silver brazing filler metals. It has a working range of 550-750°C and is recommended for use with filler metals melting below 700°C (such as the low melting point Silver-flo™ and Easy-flo™ filler metals). It is highly active very early on in the brazing cycle, exhibits very little bubbling during heating and has a relatively low viscosity when molten. These facts make it suitable for induction brazing or very fast, short heating cycles. Easy-flo™ Low Temperature Grade Flux paste formerly sold as Easy-flo™ Dipping Grade paste.

Easy-flo™ Low Temperature Grade Flux is suitable for use on all the common engineering materials (copper, brass, mild steel and stainless steel), but not aluminium. It performs particularly well on copper and copper alloys. 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: EN 1045: FH10

Melting range: 550 - 750 °C

Directions for use

In order to ensure a consistent mixture throughout, stir the flux paste well before use. The flux paste has been formulated to have a thin consistency to allow parts to be fluxed by immersion into the paste. When fluxed in this way, parts achieve a uniform thin covering of flux paste. The flux can be thinned by adding more water and is suitable for automated application in systems using mechanical pumps. Alternatively 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

Flux residue removal:

1kg plastic pots

7kg plastic pots

25kg plastic containers

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Johnson Matthey PLC, Platinum Group Metal Services, Orchard Road, Royston, Herts, SG8 5HE, UK Rev.27/01/25.