

Technical data

Brazing flux

Easy-flo™ Stainless steel grade flux paste

Product description

Easy-flo™ Stainless Steel Grade Flux Paste is a brazing flux suitable for use with silver brazing filler metals. It has a working range of 550-775°C and can be used with silver brazing filler metals melting below 725 °C (such as several of the Silver-flo™, Easy-flo™ and Argo-braze™ alloys).

It is suitable for use on all 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.

Easy-flo™ Stainless Steel Grade flux has an increased fluoride content giving improved fluxing on stainless steel, but as a result may also be more prone to exhaustion.

Conforms to: EN 1045: FH10

Melting range: 550 - 775 °C

Directions for use

In order to ensure a consistent mixture throughout stir the flux paste well before use. 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:

250g plastic pots

500g plastic pots

1 Kg plastic pots

5 Kg plastic pots

25 Kg plastic containers

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