AG ACTIVE PASTE

Paste for Silver Brazing Alloys

TECHNICAL DATA SHEET 518

Specifications:

Base	Active Temperature Range (˚C)	NF EN 1045
Complex Fluoborates	550-880	FH 10

Characteristics:

AG ACTIVE PASTE ready to use. A stream of strong brazing for Copper Stainless Steel and nickel alloys. Paste composed of mixture of Complex Fluoroborates ensuring very good protection of brazing component at high temperature. It comes in the form of a white paste **free of boric acid** and soluble borates. Paste is also available for auto dispensing equipment.
Base Metal, Copper and its alloys, Stainless Steel and Nickel Alloys. Good with Filler Metal CuP/ CuPAg/ Ag alloys

Applications:

AG ACTIVE PASTE is very good for not only for manual torch brazing but also use in the process of induction & Furnace Brazing. Being a homogeneous and stable dough, it can use in automatic dispensable unit. It used in a wide variety of joining applications for many different finished products including applications Switchgears, Farm machinery, Heat Exchanger, Heating equipment, Plumbing Fixtures, Refrigeration and Air conditioning, Ship Repair, Steel Furniture.

Direction of Use:

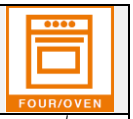
AG ACTIVE PASTE.to be stirred the mixture thoroughly before use. Apply the mixture across the joint surface before assembled by brush. Further Paste should then be applied externally on the either side of joint.
Cold Rodding where, a cold brazing rod is dipped into Paste and it adhering to the rod. The Paste is transferred to the joint area. This is an effective fluxing method, but difficult to achieve good penetration of capillary joints. It can be used to supplement a pre-fluxed area during heating. For Flame brazing, the Paste is only conditionally suitable (due to relatively short time until the flux will be saturated with oxides).
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 Flux melting is work as a temperature guide, i.e. it will become clear or opaque as brazing temperature is reached. If blackening of the surface occurs this is often sign of insufficient flux, overheating or flux.

Flux Residue Removal:

The post braze flux residue should be removed to avoid potential corrosion. Deep the component in hot water (60˚C) for 30mins and then brushing with a rag or non-woven abrasive pad. Additional measures include mechanical cleaning with a wire brush, steam jet or abrasive blasting media such as grit, soda or dry ice. If permit, quench hot brazed joint in water when reached below 300˚C (specifically Sn containing alloys). This quenching will make the flux residue more fragile and with mechanical cleaning it will remove.

Standard Packing and Storage:

Standard Packing (gm)	
500	1000
√	√

			
OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
√	√	√	√

Customised packing other than above standard dimensions is solicited case to case basis.
Flux to be stored in the temperature range +5 to 30˚C. Avoid rapid changes in temperature.

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