AGFLUX HP Paste

For CuPAg & Silver Brazing Alloys

TECHNICAL DATA SHEET 191B

Specifications:

Base	Active Temperature Range (˚C)	DIN EN 1045	Approval
Fluoro-Boro complex	500-800	FH 10	-

Characteristics:

AGFLUX HP PASTE is to be used for brazing of high Silver containing alloys as well as CuPAg. The flux remain active for wide temperature range and best for the alloys who's melting temperature is between 500-800˚C. The aggressive flux formulation gives very good fluidity and capillary action of the alloy. The flux is suitable for all flames used for brazing, Induction brazing and Resistance brazing procedures. It does not fume much.). **This Product is RoHS Compliance.** This flux can use in conjunction with our range

- Phosbraz AG XXX: To braze brass with Copper
- Brazargent 15XX & 50XX: Silver brazing alloys with melting temperature lower than 800˚C

Applications:

AGFLUX HP Paste is recommending to be used for brazing Steel, Copper, Copper Alloys as well as Nickel & Nickel alloys. Typical applications are found in electrical Industry, Construction of vehicles and in the copper tube installation. To be used with Brazargent Ternary and Quaternary alloys.

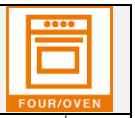
Direction of Use:

AGFLUX HP paste: 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 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 exhaustion.

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)						
200	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.