AGFLUX PASTE

Brazing Flux Paste for Silver & Copper Alloy

Flux Certified A.T.G. Certigaz

TECHNICAL DATA SHEET 17B

Specifications:

Base	Active Temperature Range (˚C)	NF EN 1045	ATG
KF-Fluo-Borates	500-800	FH 10	N°1530 et N°1614

Characteristics:

AGFLUX PASTE ready to use. Formulated as general purpose silver brazing Paste. Recommended for brazing Copper, Brass, Nickel, Steel, Stainless Steel brazing radiators, heating elements.To be Used in combustible gas installations together with our **PAG 60 (A.T.G. No.1530) or BRAZARGENT 34 GAZ (A.T.G. No.1614)**. This flux can be used in conjunction with our range

- Phosbraz: To braze brass with Copper
- Brazargent: Silver brazing alloys with melting temperature lower than 800˚C

Applications:

AGFLUX PASTE is 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:

AGFLUX PASTE.to be stirred the mixture thoroughly. Apply the mixture across the joint surface before assembled by brush. Further flux should then be applied externally on the either side of joint.

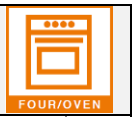
Cold Rodding where, a cold brazing rod is dipped into flux powder and flux adhering to the rod is transferred to the joint area. This is an effective fluxing method but difficult to achieve good penetration of capillary joints. It can be used to supplement a pre-fluxed area during heating. For Flame brazing, the flux 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 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)							
60	200	400	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.

Conformity

Approval concerning **BRAZARGENT 34 GAZ/AGFLUX – PAG60/AGFLUX** following A.T.G. specification B.524 and A1(2011).