BORINOX PASTE

Brazing Flux Paste for Silver Alloy

TECHNICAL DATA SHEET 418B

Specifications:

Base	Active Temperature Range (˚C)	NF EN 1045	Approval
K-Fluo-Borates	500 - 800	FH 10	-

Characteristics:

BORINOX PASTE is very active in nature and to be used with Silver brazing alloy. Flux active temperature range is 550 - 800˚C and best for the alloys whose melting temperature is between 590-730˚C.This flux is suitable for all flames, Induction and Resistance brazing procedures. It does not fume much. **This Product is RoHS Compliance.**

Applications:

BORINOX 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:

BORINOX PASTE should be stirred well before used to ensure homogenous mixture through out. Apply the mixture across the joint surface before assembled by brush. Further flux should then be applied externally on the either side of joint.

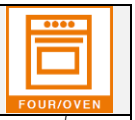
Hot Rodding is where, a warm brazing rod is dipped into flux powder and the flux adhering to the rod is transferred to the joint area. This is an effective fluxing method but difficult to achieve good penetration of capillary joints. It can be used to supplement a pre-fluxed area during heating.

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)							
150	200	400	1000				
√	√	X	X	√	√	√	√

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.