

TECHNICAL DATA SHEET 418

Specifications:

Base	Active Température Range (°C)	NF EN 1045	AWS A5.31/SFA 5.31
K-Fluo-Borates	550-870 (according to NF EN 1045)	FH 10	FB3-F

Characteristics:

BORINOX is scouring flux to be used for brazing Silver brazing alloy. The flux remain active for wide temperature range and best for the alloys who's melting temperature is between 590-730°C. The flux is suitable for all flames used for brazing, Induction brazing and Resistance brazing procedures. It does not fume much.

Applications:

BORINOX 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 flux powder should be mixed with water. Stir 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.





Hot Rodding is where, a warm 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.

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	1000				
✓	✓	✓	✓	✓	✓

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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