PHOS FLUX (L)

Liquid Flux for joining Copper & Copper Alloys

TECHNICAL DATA SHEET 519

Specifications:

Base	Active Temperature Range (˚C)	NF EN 1045
Complex borates	580-880	FH 10

Characteristics:

PHOS FLUX (L) ready to use transparent liquid Flux for Copper & Copper Alloys joining. The liquid composed of mixture of Complex borates and fluorine Salts. Give a very good protection of brazing component at high temperature.
Base Metal, Copper and Copper alloys. Good with Filler Metal CuP/ CuPAg/ Ag alloys

Applications:

PHOS FLUX (L) is very good for manual torch 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 shapes of copper and copper alloys using CuP & CuPAg alloys.
Application: Heat Exchanger, Heating equipment, Plumbing Fixtures, Refrigeration and Air conditioning,

Direction of Use:

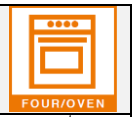
PHOS FLUX (L) has to be used in original concentration. Apply liquid across the joint surface before assembled by brush. Further liquid should then be applied externally on the either side of joint.
For Flame brazing, the liquid is only conditionally suitable (due to relatively short time until the flux will be saturated with oxides).
It is good practice to mechanically clean and degrease the joint surface before applying liquid. Heat slowly and evenly to the brazing temperature, without local overheating.

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 or by mechanical cleaning.

Standard Packing and Storage:

Standard Packing (L)			
0.5 L	1 L	5 L	10 L
√	√	√	√

 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.

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.