POLYFLUX

Brazing Flux for Braze-welding

TECHNICAL DATA SHEET 10

Specifications:

Base	Active Temperature Range (˚C)	NF EN 1045
Mix of Fluorides and Borates	800-1000	FH 20

Characteristics:

POLYFLUX is in Powder or Paste form is ready to use for general brazing alloys and autogenous cast brazing. Its aggressive action gives perfect cleaning on uncleaned surface. It improves brazing alloys fluidity. The flux remain active for wide temperature range and best for the alloys who's melting temperature is >700˚C. 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

- **Cuprox, Nicrox, Super Cuprox/Nicrox (1%Ag) and Brazargent 1505, 1512Si, 1520Si.**

Applications:

POLYFLUX 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:

POLYFLUX 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.

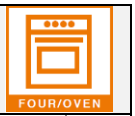
Hot Rodding is where, a warm brazing rod is dipped into flux powder and flux adhering to the rod is transferred to the joint area. This is an effective fluxing method but difficult to achieve good penetration of capillary joints. It can be used to supplement a pre-fluxed area during heating.

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)							
60	200	400	1000	OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
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.

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.