

# Product Information

## Flux for silver solders “CuFe Nr.1 Spezial”

Hard soldering flux with a activity range of 520 – 1030 °C  
Type FH 12 according to DIN EN 1045

Item-No.: 261000 ...

All information about our products are the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

**Flux for silver solders "CuFe Nr.1 Spezial"**

## Description

Based on boron compounds, fluorides, boron

### Standards

DIN EN 1045: FH12  
AWS A5.31-92R: FB3-C

**FELDER hard soldering flux "CuFe Nr.1 Spezial" does not contain any substances, in concentrations or application, whose bringing into circulation in products is prohibited according to the valid requirements of the directive 2011/65/EU ("ROHS").**

## Properties

Working temperature range: approx. 520 - 1030 °C  
Color: brown  
Density: approx. 1,6 g/cm<sup>3</sup> (20 °C)  
Viscosity: 150 - 250 dPa s (Haake Viscotester 02, Sp.2, 20 ±2 °C)  
Flux residues: corrosive, water-soluble

## Application

Flux for brazing stainless steel and cemented carbides.  
FELDER "CuFe Nr.1 Spezial" paste is suitable for all flame and induction brazing procedures.  
Typical applications are found e.g. in the tool industry.

## Further Information

Stir well before use. Only a homogeneously mixed paste will display constant and repeatable performance.  
Additions of water may negatively alter these parameters.

## Residues

The flux residues are corrosive and have to be removed by washing or by pickling.

## Delivery forms

0,100, 0,250, 0,500, 1,000 kg bottles

## Storage advices

Shelf life min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30 °C. Avoid rapid changes in temperature.