

Product Information

Brazing flux paste “UNIVERSAL”

Brazing flux with a activity range of 750 – 1100 °C

Type FH21 B according to EN ISO 18496 (outdated EN 1045)

Item-No.: 262500 ...

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.

Description

FELDER "UNIVERSAL" brazing flux paste is a brazing flux based on boron compounds for brazing copper, copper alloys, gray cast iron, malleable cast iron and steel as well as for welding brass. The "UNIVERSAL" **brazing flux paste** has a large effective temperature range, optimized for the highest soldering requirements in industry and trade. Due to its formulation and classification, this brazing flux paste is also suitable for do-it-yourselfers and therefore for distribution through hardware stores.

Properties

Formation	:	pasty
Working temperature range	:	750 - 1100 °C
Colour	:	white

Application

Clean the soldering joint from oxide films, scales, clinker, oil and grease. Dispense flux on the work piece by coating . The direct area around the soldering joint should also be provided with flux. After this heat the work piece up to working temperature (orange red). Join the brazing rod. The flame should be adjusted slightly reductive (gas surplus). Stir or shake the paste well before usage.

According to the application area the following hard soldering rods and welding wires can be used:

Silver hard solders with working temperatures above 750 °C (Ag 212, Ag 225, Ag 401 etc.)

Brass hard solder	Cu 670 - EN ISO 17672 (L-CuZn40 - DIN 8513),	Art.-No.:3000....
Special brass hard solder	Cu 681 - EN ISO 17672 (L-CuZn39Sn - DIN 8513),	Art.-No.:3010....
Nickel silver hard solder	Cu 773 - EN ISO 17672 (L-CuNi10Zn42 - DIN 8513),	Art.-No.:3020....
Copper welding wire	Cu 99,9 - Cu-DHP (SF-Cu)	Art.-No.:3100....
Copper welding wire	Cu 1898 - EN ISO 24373 (SG-CuSn - DIN 1733),	Art.-No.:3101....
Copper welding wire	Cu 6560 - EN ISO 24373 (SG-CuSi3 - DIN 1733),	Art.-No.:3102....
Copper welding wire	Cu 1897 - EN ISO 24373 (SG-CuAg - DIN 1733),	Art.-No.:3103....

Residues

The flux residues are non-corrosive and, therefore, can remain on the solder joint. If necessary, these can be removed mechanically, with water or caustic.

RoHS

FELDER brazing flux paste "UNIVERSAL" 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").

Storage advices

Store in tightly closed containers protected by humidity, insolation, and warmth effect.

Minimum durability

24 months from production date.

Delivery forms

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