



stts

Brazing solutions

Z.A.E. la Neuville 60240 FLEURY (France)

☎ : (33) 3.44.49.02.19 📠 : (33) 3 44.49.11.40

✉ : stts@stts-flux.com

TECHNICAL DATA SHEET

FLUX ORGANIC FLUX 1015

ZINC FREE – NON CORROSIVE

FOR FURNACE SOLDERING AND TORCH SOLDERING

➤ **1** PRODUCT DESCRIPTION

- Non corrosive product – Zinc free
- Good stability at standard brazing temperatures (Lead, Tin) during the brazing phase, then the flux is burnt off.
- Post brazing : no corrosive residues. The parts remain inert

➤ **2** CHARACTERISTICS – PHYSICO –CHEMICAL PROPERTIES COMPOUND ELEMENTS

MAIN CHARACTERISTICS

- Intended for the complete manufacture of copper/brass radiators
- Non corrosive flux
- Great pickling powder
- Good wettability of both flux and filler alloy
- Good stability for direct torch soldering

PHYSICAL PROPERTIES

- Clear liquid
- Density : 1.16
- PH +/- 2.10

Date de révision : 02/01/08 JPF
I.R : 1





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COMPOSITION

- . Amine salts
- . Wetting agents

③ ➤ PRODUCTS APPLICATIONS

- Organic flux 1015 is formulated to be used in the manufacture of copper/brass radiators by dipping, spraying, or manual brushing

All kinds of assembly methods are possible :

- Core baking
- Header dip + Tube/tube plate bonding
- Torch soldering- Accessories fitting

④ ➤ DIRECTIONS FOR USE

No post-soldering washing necessary

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RECOMMENDATIONS

- Fluxing : by manual brushing, by dipping or by spraying
- Dilution in water (Those values depend on each process and will be adjusted during preliminary tests)
 - . Strip tinning = 20 à 50 %
 - . Tube to header soldering = 33 %
 - . Core baking = 5 à 20 %
 - . TORch soldering = 30 % to 100 %

⑤ ➤ USING CARE AND RECOMMENDATIONS

When used, the flux 1015 does not produce any kind of harmful fumes. It is odourless and safe.

Due to its specific compounds, Flux 1015 satisfies environmental regulations as well as the technical requirements of the user

For all other information, please see the Material Safety Data Sheet also available on our web site (www.stts-flux.com) or contact us directly

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