



# stts

Brazing solutions

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## TECHNICAL DATA SHEET

# ORGANIC FLUX 1011

ZINC FREE – NON CORROSIVE  
FOR FURNACE SOLDERING AND TORCH SOLDERING

## ➤ 1 PRODUCT DESCRIPTION

Derived from Organic flux 1010, its strengthened free acidity gives him a higher pickling power.

- Non corrosive flux with good pickling ability.
- 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 power
- Good wettability of both flux and filler alloy
- Good stability for direct torch soldering

### PHYSICAL CHARACTERISTICS

- Yellow/brown liquid
- pH of 20 % Solution < 1
- Density : 1.250 +/-0.002

Date of review : 30/03/04 JPF  
I.R : 1





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### COMPOSITION

- Bromhydric acids
- Amine salts
- Wetting agents
- Inhibitors

### ③ ➤ PRODUCT APPLICATIONS

- Organic Flux 1011 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 in most cases.
- Fluxing : by manual brushing the material remains corrosion free
  
- Dilution in water (Those values depend on each process and will be adjusted during preliminary tests)
  - Strip tinning = 20% to 50 % (volume/volume in water)
  - Tube to header soldering = 10% to 30% (volume/volume in water)
  - Core baking = 5% to 20 % (volume/volume in water)
  - Torch soldering : 30 % to 100% (volume/volume in water).

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### 5 ➤ USING CARE AND RECOMMENDATIONS

- When used, the flux 1011 does not produce any kind of harmful fumes. It is odourless and safe.
- Due to its specific compounds, Flux 1011 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](http://www.stts-flux.com)) or contact us directly.

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