



stts

Brazing solutions

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

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✉ : stts@stts-flux.com

TECHNICAL DATA SHEET

SOLDERING OF COPPER AND COPPER ALLOYS

MINERAL FLUX 1001 STRONG PICKLING FLUX

➤ DESCRIPTION – PRESENTATION.

Mineral flux 1001 has a great pickling power. Its wettability is excellent, the eutectic is minimised as much as possible. The flux is stable at high temperature, even with flame heating.

Mineral flux 1001 is highly concentrated, is safe to use and generates good cost savings.

➤ CHARACTERISTICS - PHYSICO-CHEMICAL PROPERTIES, COMPOUND ELEMENTS.

Mineral flux 1001 has the following specific composition :

- Acids and mineral acids salts in aqueous solution
- Wetting agents, inhibitors
- Vapour absorber

PHYSICAL AND CHEMICAL PROPERTIES

Appearance : clear liquid

Colour : Blue

Density at 20°C : 1.515 +/- 0.001

Ph at 20°C : 1

MAIN PROPERTIES

Highly concentrated product

Excellent wettability

Stable at high temperatures

Great pickling ability

Post braze cleaning of parts is essential.

Date of review : 25/03/04 JPF

I.R : 1





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③ ➤ PRODUCT APPLICATIONS.

Mineral Flux 1001 is intended for the preparation of copper alloys for brazing processes using lead/tin) or lead/tin/silver (low silver content) filler metals.

④ ➤ DIRECTIONS FOR USE.

The pieces are fluxed by dipping, spraying or hand brushing them.

The brazing is done either in a furnace, by torch soldering or by dipping in a tinning bath

GENERAL USAGE CONCENTRATIONS

- Core brazing : 5 to 20% in water
- Torch soldering : 30% in water
- Collector brazing : 30% in water

The control of the fluxing bath is done by checking its density.

The brazing is followed by rinsing in water and then washing with acid to remove any residual salts which could cause corrosion.

⑤ ➤ USING CARE AND RECOMMENDATIONS.

Avoid direct contact with skin and eyes.

Wear protective clothing, gloves, glasses as necessary.

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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