



stts

Brazing solutions

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TECHNICAL DATA SHEET

COPPER AND ITS ALLOYS BRAZING

ORGANIC FLUX 1010

ZINC FREE – NON CORROSIVE
FOR FURNACE SOLDERING AND TORCH SOLDERING

➊ ➤ PRODUCT DESCRIPTION

- 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.

➋ ➤ 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 1010 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

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% to 50 %
 - Tube to header soldering = 33 %
 - Core baking = 5% to 20 %)
 - Torch soldering : 30 % to 100%

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5 ➤ USING CARE AND RECOMMENDATIONS

- When used, the flux 1010 does not produce any kind of harmful fumes. It is odourless and safe.
- Due to its specific compounds, Flux 1010 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.