



**stts**  
Brazing solutions

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FICHE  
TECHNIQUE

## PROTINFLUX 1001

### Strong pickling flux

Date de révision :  
04/11/2014 JPF  
IR : 3

#### . DESCRIPTION – PRESENTATION

PROTINFLUX 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.

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

#### . CHARACTERISTICS - PHYSICO-CHEMICAL PROPERTIES, COMPOUND ELEMENTS

PROTINFLUX 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

#### . PRODUCT APPLICATIONS

PROTINFLUX 1001 is intended for the preparation of copper alloys for brazing processes using lead/tin, tin/copper or tin/silver (low silver content, usually 3,5%) filler metals.

ISO 9001  
ISO 14001  
BUREAU VERITAS  
Certification





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**TECHNICAL  
DATA SHEET**

# PROTINFLUX 1001

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## **. DIRECTIONS FOR USE**

The parts are fluxed by dipping, spraying or hand brushing.  
The brazing is done either in a furnace, by torch soldering or by dipping in a tinning bath.

GENERAL DILUTIONS TO APPLY FOR H.E. MANUFACTURING:

- Core baking: 5 to 20% in water
- Torch soldering: 30% in water
- Header plates 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 hydrochloric acid to remove any residual salt which could cause corrosion.

## **. USING CARE AND RECOMMENDATIONS**

For all other information please see the Material Safety Data Sheet also available on demand

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