



stts
Brazing solutions

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TECHNICAL DATA SHEET

PROTINFLUX 1009

Soldering of copper and copper alloys strong pickling flux

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

. DESCRIPTION – PRESENTATION

PROTINFLUX 1009 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 1009 is highly concentrated, is safe to use and generates good cost savings.

. CHARACTERISTICS - PHYSICO-CHEMICAL PROPERTIES, COMPOUND ELEMENTS

PROTINFLUX 1009 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 : 1.52 to 1.53

Ph at 20°C : 2 to 3

MAIN PROPERTIES

Highly concentrated product

Excellent wettability

Stable at high temperatures

Great pickling ability

Post braze cleaning of parts is essential.

. PRODUCT APPLICATIONS

PROTINFLUX 1009 is intended for the preparation of copper alloys for brazing processes using lead/tin) or lead/tin/silver (low silver content) filler metals.

ISO 9001
ISO 14001
BUREAU VERITAS
Certification





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. DIRECTIONS FOR USE

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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.

. USING CARE AND RECOMMENDATIONS

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

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