




# flux

Reference	Powder	Paste	Use interval	Standard EN1045	Main applications
<b>CUPRO-FLUX</b>	X	X	800-1000°C	FH20	Flux for braze-welding and brazing. Allows large clearances to be used. Main application on carbon steel. For use with CUPROX, SUPER-CUPROX and BRAZARGENT 1505.
<b>POLY-FLUX</b>	X	X	800-1000°C	FH20	Promotes the flow of filler metal. Extremely efficient, it permits brazing even on dirty surfaces. For use with CUPROX, SUPER-CUPROX and BRAZARGENT 1505.
<b>PHOSBRAZ-FLUX</b>	X		600-850°C	FH20	Flux powder recommended for brazing brass connections on copper piping with our Phosbraz alloy range.
<b>GEL 60</b>			600-850°C	FH10	Certified by ATG (French Ministry of Industry) it is suitable on copper piping for combustible gas installations. To be used with our PAG 60, registration n° 750. 
<b>GEL 400</b>			500-800°C	FH10	Certified by ATG (French Ministry of Industry) for combustible gas installations. To be used in combination with our BRAZARGENT 400, registration n° 1512. 
<b>AGFLUX</b>	X	X	500-800°C	FH10	High quality flux. Well suited for brazing steels and copper-based alloys, as well as on piping for combustible gas installations. Certified with BRAZARGENT 400 and PAG 60, registration n° 1529 and n° 1530. 

## WHY TO USE A FLUX?

Nearly all metals exposed to the atmosphere get easily oxidized. The higher the temperature, the higher the oxidation !

Certain brazing welding alloys, such as PHOSBRAZ® are self-fluxing at the brazing temperature, when used on pure copper. Phosphorus in the filler material reduces the copper oxide. In all other cases, the use of a flux is necessary.

The flux is used to permit proper formation of the joint due to three main actions: protection of joint surfaces against oxidizing during heating, dissolution of metallic oxides and removal of residues generated during the process, wetting of the surfaces to be assembled to permit adequate migration of the filler metal in the joint.

For each operation, the flux must be selected, according to :

- joint materials,
- filler alloy selected,
- temperatures, heating mode and duration.

This means no «universal» flux exists, for all applications. The REB® flux range makes it possible to meet most problems encountered.

## REMARKS

All brazing fluxes contain aggressive products. Therefore, we suggest the following:

- Work place : remove all flux waste to avoid further corrosion. Our fluxes are soluble in hot water or slightly alkaline solutions.
- Personnel: avoid fume breathing, use safety glasses and glove protection, use enough ventilation.

Flux dosing depends on the property and the oxidation of pieces.

## PACKAGING

- Units of 200 g.
- Units of 400 g.
- Units of 1000 g.
- Units of 5 liter
- Units of 10 liter

