



HILCO BRONZE FLUX

Flux – non ferrous – brazing

HILCO Bronze Flux is suitable for use on copper, brass, mild steel and most other common materials.

HILCO Bronze Flux is available in powder only. This powder can be made into a paste by stirring in water until the mixture has the consistency of thick cream. The flux can be applied by hot prodding i.e. dipping a warm rod into flux powder and the flux adhering to the rod is transferred to the joint area.

A molten brazing alloy will only wet and flow over a parent metal if both are substantially free of surface oxide. Simply removing surface oxide before brazing is not effective, since a new oxide layer is rapidly formed on heating. To achieve a oxide free surface it is necessary to:

- Remove oxide as it is formed using a suitable brazing flux, or
- Prevent oxidation during brazing by heating in a protective atmosphere, or
- Use a self-fluxing brazing alloy (possible when copper-to-copper brazing only!)

Brazing Flux	Application	EN 1045	Temperature range	Packaging	To be used in combination with
Bronze flux	General purpose, brazing cast iron, steel, brass, bronze and copper	FH 21	750-1100°C	500 gr. jars	Bronze C

Flux residue removal

We recommend to remove flux residues after brazing, due to the danger of corrosive attack when the flux hydrolyses on exposure to moist air. The method of removal depends on the classification of the brazing flux.

Classification	Removal of residues
FH21	Residues are non-corrosive and have to be removed mechanically or by pickling