TECHNICAL DATASHEET

Brazing Flux BrazeTec Soldaflux K

TD EN Soldaflux K REV.2

Composition and technical data:

Composition (% in weight)	Zinc chloride, Ammonium chloride
Colour	Transparent
Working temperature (°C)	150-450
Density (g/cm^3)	1,5
Chemical characteristics	-
PH	-
Solubility	-
State of product	Liquid
Residues	Residues are corrosive and have to be removed with water and mechanical rubbing
Standard EN 29454-1	3.1.1.A
Shelf life	12 months, but only in the original sealed container at storage temperatures between +5 to +30 °C.

Applications
Plumbing technology, electrical industry

Operating conditions
Flux for soft soldering process. Excellent for removing surface oxides. Used for joining steel, copper and copper alloys, as well as nickel and nickel alloys.

Recommended alloys
Soldamoll 210,220,220A,230,230A,235,240,300, BrazeTec 3, BrazeTec 4, Darifix 3

Heat source
Flame, induction heating, resistance

Notes
Especially suitable for carbon steels and nonferrous metals.

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