

PROTINFLUX 1010

Classification selon norme : EN 9454-1 (2016) 2.1.2.4

ISO 9001
ISO 14001

BUREAU VERITAS
Certification



APPLICATION FIELD

PROTINFLUX 1010 is formulated for the brazing of copper/brass radiators. It is usable at all manufacturing steps.

It has a good stability at standard brazing temperatures.

It is eliminated by sublimation during the brazing process and don't leave any residue.

After brazing, the parts remain inert as there are no corrosive residues.

CHARACTERISTICS, CHEMICO- PHYSICAL PROPERTIES

Liquid flux, odorless

Colorless to Yellow

Density: 1.24-1.26

pH (100%) <0

Application temperature: 280 - 450°C

It does not contain any mineral salts, so it curbs environmental pollution.

DIRECTION FOR USE (1)

Fluxing application is possible by manual brushing, dipping, or spraying.

All kinds of assembly methods are possible:

- Core baking
- Header dip + Tube/tube plate bonding
- Torch soldering – Accessories assembly

Dilution in water:

- Strip tinning = from 20% to 50%
- Tube to header soldering = 33 %
- Core baking = from 5% to 20%
- Torch soldering = from 30% to 100%
- Soldering iron = 100 %

(these values depend on each process and must be adjusted during preliminary tests)

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DIRECTION FOR USE (2)

When the flux is entirely eliminated during the manufacturing process, there is no corrosive residue, therefore no cleaning step is necessary after brazing process.

When there is an excess of flux: “black” marks appear on the surface of the core, which means flux has not burned properly during oven stage.

When there is no sufficient flux: cracklings may appear on joints.

=> In both cases, dilution ratio flux/water must be adjusted.

PACKAGING

Plastic can of 5 Kg

Drum of 35 Kg or 250 Kg

MISCELLANEOUS

All active materials are in compliance with REACH.

Refer to MSDS (Health and Safety data sheet) – available on demand.

Note: The contents of this data sheet result from our knowledge and experience of the product, given as an indication but does not engage our responsibility for each particular case.