



ActivaTec 1000

Water Soluble Flux for Stainless Steels

Typical Applications :

- Joining and repairing stainless steel and other steel parts in conjunction with E+C ThinFlo and UltraMax silver type alloys.
- Large batch or production line jobs as a means of saving considerable time and alloy material.
- Applications in the Food and Chemical industries when used with E+C ThinFlo alloys which are high in silver content and free of cadmium.
- The manufacture of surgical instruments and kitchenware.
- ActivaTec 1000 Flux is excellent for difficult to wet metals and unusual joint designs. In addition to use on steels and stainless steels (including 300,400 and 500 types), it is also recommended for nickel and copper alloys.
- Especially recommended for protection of adjacent surfaces against oxidation and tarnishing. Simply apply on the entire surface to be heated.
- ActivaTec 1000 Flux is also recommended for use with aluminium-bronze type alloys.

Description :

ActivaTec 1000 has been designed by the Eutectic+Castolin[®] Centre for Scientific Research for superior quality joining with extra productivity, when used with the E+C ThinFlo and UltraMax exclusive range of silver alloys.

ActivaTec 1000 is a unique EutecTor[®] Flux that dramatically protects stainless steel components against oxidation (discolouration) during joining. Even after prolonged overheating, ActivaTec 1000 continues to protect and enhance the wettability of the silver joining alloy. Also recommended for use on entire heated surfaces to prevent oxidation.

Users will realise savings in post-joining cleaning to remove heat tint as well as flux removal labour costs since residues are completely soluble in water which speeds up cleaning.

Characteristics :

ActivaTec 1000 Flux provides super activity combined with exceptional resistance to overheating and ability to withstand breakdown by high temperatures for extended periods of time, especially when used on stainless steel. It is recommended for use with all silver bearing alloys melting between 400°C and 840°C. Because of its high concentration, ActivaTec 1000 Flux has little or no tendency to separate or split while being brought to its melting temperature. This is accomplished by a combination of micro-pulverisation and double homogenisation.

- **READY TO USE:** Brush or swab application of this thin consistency EutecTor[®] Flux paste is easy.
- **ALL-POSITION:** Applied with a brush, it will not run even in overhead position
- **EXTRA AND EXTENDED DEOXIDIZING STRENGTH:** Ability to dissolve oxides efficiently even during prolonged heating.
- **EXTRA ATMOSIN[®] WETTABILITY:** Prevents flux film from "beading" both when base metal is cold and when heated.
- **LITTLE OR NO GLARE:** Perfect visibility of the alloy pool reduces risk of overheating the base metal.
- **NO WASTE OF METAL:** Optimum wettability ensures efficient use of filler alloy
- **EASY REMOVAL OF RESIDUE:** Saves valuable time. Quenching while still warm will help flux removal. Wash off by surface agitation or scrubbing with brush & warm water.
- **REDUCES CONSUMPTION OF SILVER ALLOY:** Super concentration, super activity and super high heat resistance help to reduce the amount of silver alloy needed.

Application Procedure:

- Clean the parts to be assembled thoroughly.
- Stir ActivaTec 1000 to obtain a paste of even consistency. Add distilled water if necessary.
- Apply with a clean brush to the entire surface of all parts to be assembled
- Close the container carefully after use.

Technical Data:

Type: Paste

Colour: White

Solubility: In distilled water

Removal of flux residue: Soluble in both hot and cold water

Range of activity: 400°C - 840°C

Base metals applicable: Stainless and other steels, copper and nickel alloys.

Behaviour of flux residues: Corrosive in humid environment.

DIGITALWELD

J.D.M Holdings Ltd

Unit D/17 Hobill Avenue, Wiri, Manukau, 2104. P.O Box 97622 Manukau City, Manukau 2241, New Zealand
Ph: +64 (09) 263 7099 Fax: +64 (09) 263 5062 Email: sales@digitalweld.co.nz Website: www.digitalweld.co.nz