



EutecSol Flux 157

For Stainless Steels, Ferrous Metals and
Copper based alloys

Description:

EutecSol flux 157 is an efficient deoxidiser, and helps the filler alloy to spread evenly in the joint, rendering it tight and mechanically strong.

- For stainless steels, ferrous metals and copper based alloys
- Joining of dissimilar metals
- Efficient deoxidiser
- Promotes wetting out of the filler alloy
- Easy removal of flux residues

Technical Data:

Activity Range.....150-450°C

State.....Liquid

Colour.....Translucent

Dilution.....When necessary to dilute (max 10%)

Do so with distilled or mineral-free-water only.

E+C ThinFlo alloys.....157 (154/197 and others which may be recommended by Eutectic + Castolin)

Applications:

Food processing, chemical, air conditioning and refrigeration, micro-technology and general engineering, electronics, household appliances, plumbing and other building installations.

Tubular assemblies, copper and stainless steel piping.

Fabrication of filters and washing installations.

Heat exchangers.

Manufacture of medical and surgical equipment.

Manufacture of measuring instruments.

Electronic components, waveguides, electrical contactors.

Manufacture of household articles and kitchen equipment.

Artistic works.

Health and Safety :

Corrosive:

Contains Zinc Chloride.



Avoid inhaling the fumes, adequately ventilate the work area.

The brazing fluxes are active chemical components. Read the indications on the packaging.

Follow the legislation for disposal of chemical substances.

European Union (EU) :

R34 Causes Burns.

S26 In case of contact with eyes, rinse immediately with plenty of water, and seek medical advice.

S36/37/39 Wear suitable protective clothing, gloves and eye/face protection.

S45 In case of accident or if you feel unwell, seek medical advice immediately (show the label where possible.)

S51 Use only in well ventilated areas.

A safety data sheet according to the directive 91/155/EEC is available.

Procedure for use:

Preparation:

Clean joint surfaces, eliminating all trace of grease and oxides.

Round off corners slightly, and sharp edges.

Apply EutecSol Flux 157 to whole joint area and on the E+C ThinFlo filler rod.

If necessary, secure components in place for exact gap distance.

Torch Procedure:

Employ a neutral or slightly carburising flame. Heat assembly slowly, making sure components have the same temperature.

On reaching the working temperature (slight bubbling of flux) melt the required amount of alloy with steady heat input. The alloy will flow towards the area of greatest heat.

Avoid concentrating flame on alloy. Do not overheat.

Other heat sources may be used, such as furnace, HF, Soldering iron, etc.

Removal of Flux Residues:

Allow the assembly to cool.

Carefully remove flux residues with hot or cold water brushing if necessary and not neglecting areas of difficult access, to avoid any risk of subsequent corrosion.

Dry the assembly.

Storage and Handling:

Should be kept out of reach, in a closed container, at room temperature.

Shelf life : 2 years.

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