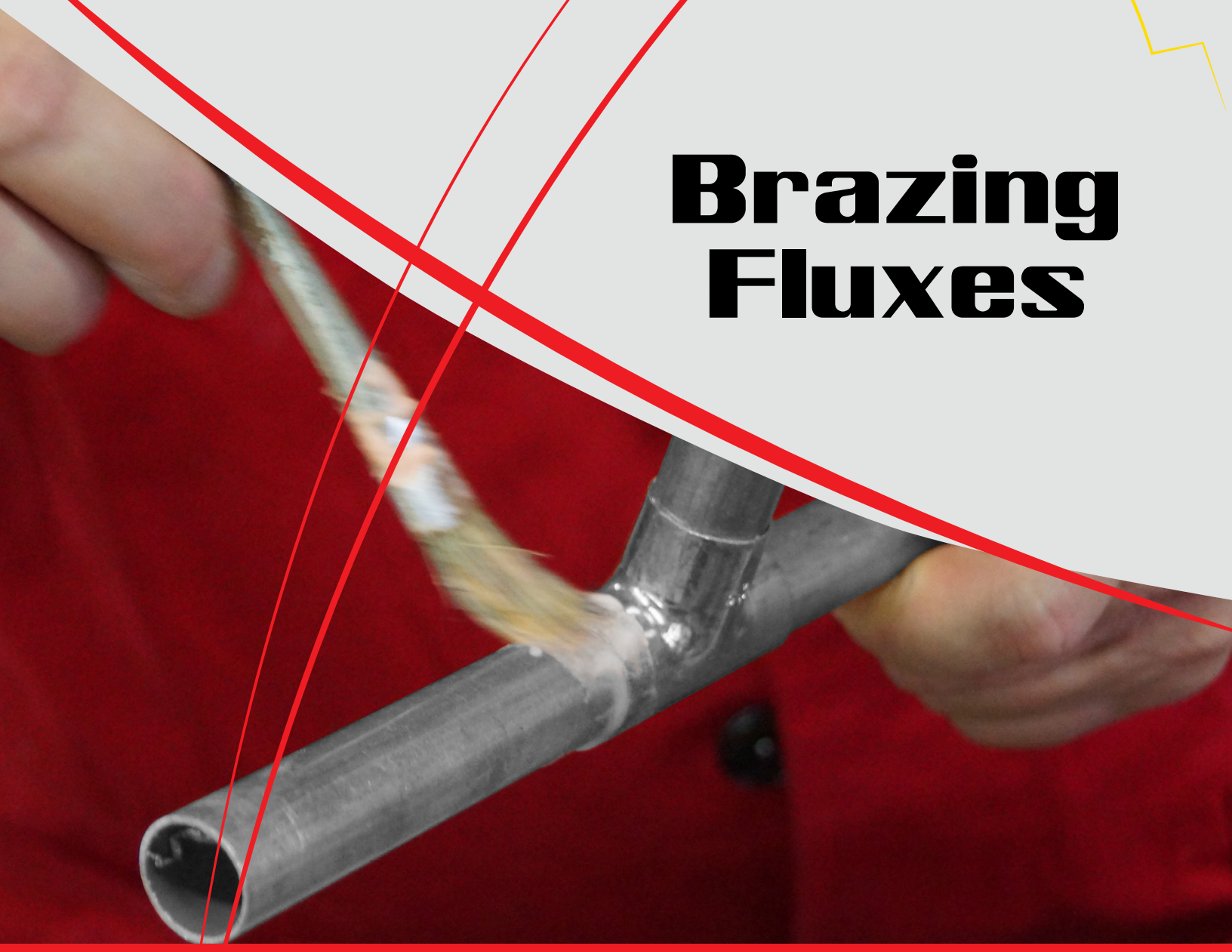
Castolin Eutectic®
Eutectic Castolin

Brazing Fluxes



- General brazing and soldering fluxes for cleaner brazements
- Easy to use, dry and paste versions for all brazing applications
- Uniquely formulated for outstanding capillary action and flow

Brazing and Soldering Fluxes

Quality fluxes prevent surface oxidation as the temperature rises during the brazing process. Below are some key features of Castolin Eutectic's fluxes.

- *Reduce surface tension between the alloy and base metal*
- *Promote surface alloying by controlled diffusion*
- *Protect from atmospheric contamination*
- *Ensure good capillary action and flowability*
- *Have the right consistency for easy application*

Xuper Braze®

XuperBraze® 190 FP	A uniquely formulated "dispensable" flux for use with the 1xxx And 3xxx grade aluminum alloys. Excellent when used with difficult-to-braze alloy 6061. Flux has a higher oxide dissolving capacity, improved flowability, and outstanding capillary action for cleaner brazements. Meets the AWS specifaction A5.31-92 under Type FB1A. Also meets the AMS 3412D specification.	• Residues are water soluble • For use when brazing with BAISi group alloys (2, 3, 4, 7, 5) and Alcoa 719 • Temperature range: 915°F-1350°F(490°C-735°C) • No flash point - water base • Form: Ultra creamy paste • Color: White
XuperBraze® 14D	XuperBraze 14D is an active high temperature dry brazing flux for the "hot brazing" of cast irons using high-silicon brazing rods such as EutecRod® 141. 14D can be mixed with deionized water to make a cream paste. Meets the AWS specification A5.31-92 under type FB3D.	• Residues are water soluble • Does not burn - no flash point • Temperature range: 1400°F-2200°F (760°C-1205°C) • Form: Powder
XuperBraze® 100	XuperBraze 100 is a highly active flux. For use when brazing brasses, bronzes, general copper-base alloys, carbon steels, including stainless and nickel alloys. Meets the AWS specification A5.31-92 under type FB3A.	• Residues are water soluble • Use when brazing with the BAg & BCuP group alloys • Temperature range: 1000°F-1600°F (540°C-870°C) • No flash point- water-base • Form: Ultra creamy paste • Color: White
XuperBraze® 100H	This flux has a broader active temperature range compared to Xuper Braze 100. Used when localized overheating is experienced or when there is a large volume of refractory oxides present. Meets the AWS specification A5.31-92 under type FB3A.Also meets AMS 3410 3 and Fed. Spec. O-F 499 Type B.	• Residues are water soluble • Use when brazing with the BAg & BCuP group alloys • Temperature range: 1000°F-1700°F (540°C-927°C) • No flash point- water-base • Form: Ultra creamy paste • Color: Brown
XuperBraze® XF100HDS	XuperBraze XF100HDS is a special dry flux with coarse particles ideally suited for flux pot applications. Formulated for a broader active temperature range where localized overheating may occur, and uniform fluid fluxing is desired. Particle is coarser to avoid foaming in hot flux bath.	• Residues are water soluble • For use when soldering 300 series stainless steels • Temperature range: 1000°F-1750°F (540°C-955°C) • Form: Coarse powder • Color: Light brown

EutecSol®

EutecSol 682	A special soldering flux for use with difficult-to-solder metals such as the AISI 300 series stainless steels. When soldering polished stainless steels make sure to lightly roughen the surface to help with wetting. Use ExFlux 1005 followed by a hot water rinse.	• Remove residues with ExFlux 1005 • For use when soldering 300 series stainless steels • Temperature range: 450°F-460°F (230°C-237°C) • Form: Liquid • Color: Clear
EutecSol 808	Specially formulated for soldering with air-gas torches and electric soldering irons. Excellent for use on copper components in the electrical and electronic industries. Flux residues are typically non-corrosive. Use ExFlux 1005 followed by a hot/cold water rinse if acceptable to end user.	• Remove residues with hot water • For use when soldering copper connectors and potable containers • Temperature range: 420°F-430°F (215°C-220°C) • Form: Semi-liquid • Color: Brown

EutecTor®

EutecTor® 16	Specially formulated paste flux for improved wettability on low, medium, and high carbon steel, including selected tool steels. Excellent pool visibility with good build-up and free flowing properties. Particularly effective when used to braze the common brasses and bronzes. *Use a water bath to "shock off" the residues.	• Remove residue by shock* • Versiatile flux for use with EutecRod 16 or, supplementary, with 16XFC • Temperature range: 1400°F-2200°F (760°C-1205°C) • Form: Paste • Color: White
EutecTor® 16B	Similar applications to EutecTor 16 but more active. Particularly useful when brazing tool steels. Excellent pool visibility with good build-up and free flowing properties. Effective when used to braze the common brasses and bronzes. *Use a water bath to "shock off" the residues.	• Remove residue by shock* • Versatile flux for use with EutecRod 16 or, supplementary, with 16XFC • Temperature range: 1400°F-2200°F (760°C-1205°C) • Form: Paste • Color: White
EutecTor® 16D	Similar to EutcTor 16 but in powder form. Excellent for "application sprinkling".	• Form: Powder • Color: White
EutecTor® 51	For use when torch soldering selected series 1xxx, 3xxx, 4xxx, and 5257, 557, 6061 aluminum grades. Use ExFlux 1005 followed by a hot water rinse. CAUTION! Do not use flux for moist service, as this could lead to severe corrosion problems.	• Remove residues with ExFlux 1005 • Use when soldering selected aluminum grades • Temperature range: 400°F-430°F (205°C-220°C) • Form: Semi-liquid • Color: Amber
EutecTor® 157	A highly reactive flux for use primarily with stainless steels. It is formulated to dissolve the chromium oxide layer to promote improved wetting. Also very effective when soldering many of the copper-base alloys. When soldering polished stainless steels make sure to lightly roughen the surface to help with wetting.	• Remove residues with ExFlux 1005 or hot water rinse • Use when soldering 300 series stainless steels • Temperature range: 450°F-470°F (230°C-240°C) • Form: Semi-liquid • Color: Pink
EutecTor® 190	A higly recative flux for the torch brazing of aluminum and aluminum alloys. The flux is particularly suitable when brazing such common grades as EC, 11xx, 4xxx, and selected 5xxx alloys. CAUTION! Flux residues must be removed to prevent time-in-service corrosion.	• Remove residue with hot water • Use when brazing various aluminum assemblies and components • Temperature range: 1060°F-1150°F (570°C-620°C) • Form: Powder • Color: White
EutecTor® 1020D	A special dry powder flux for ease of customer mixing using distilled and deionized water. Excellent activity on many brazeable metals such as stainless steel, nickel alloys, copper base alloys. Use ExFlux 1005 followed by a hot water/cold water rinse if acceptable to the end user.	• Remove residues with hot water • Special dry flux for "customized" mixing • Temperature range: 1200°F-1600°F (650°C-870°C) • Form: Powder • Color: White
EutecTor® 1601	Formulated for use when brazing tungsten carbides to assorted machining tools. It has synergistic properties when used with EutecRod 1601. Good shock-loading resistance. Use ExFlux 1005 followed by a hot/cold water rinse if acceptable to the end user.	• Remove residue with hot water • Application-specific flux for carbide tool brazing • Temperature range: 1060°F-1600°F (570°C-870°C) • Form: Paste • Color: White
EutecTor® 1800	Customized for ease-of-use when brazing most ferrous and non-ferrous metals. Excellent oxide dissolving (take up) properties and "clear pool" visibility. Use ExFlux 1005 followed by hot/cold water rinse if acceptable to then end user.	• Remove residue with hot water • Synergistic formula for use with EutecRod 1800 • Temperature range: 1060°F-1600°F (570°C-870°C) • Form: Paste • Color: White

Specialty Fluxes

Green ActivaTec® 1000	Flux paste recommended for brazing stainless steel alloys with a high silver content. Green ActivaTec 1000 is a brazing flux with a uniform composition and particle size that ensures excellent adhesion to hot rod. This distinctive feature enables the optimal amount of flux for the brazing process. This unique formulation allows for a clear view of the brazing area, without any interference from the flux. It is ideal for all applications in food processing and chemical industries, as they have high silver content and no cadmium.	• Easy to remove residues • Use when soldering 300 series stainless steels • Temperature range: 752°F-1472°F (400°C-800°C) • Form: Paste • Color: white
WonderFlux	A highly active formula for use with a broad range of silver brazing products. It is particularly effective when used to braze the AISI 300 stainless steels. It can be used as a supplemental flux with most of the EutecRod series of silver brazing rods. Use ExFlux 1005 followed by hot/cold water rinse if acceptable to then end user.	• Remove residue with hot water • Special flux for use when brazing metals with tenacious oxides • Temperature range: 1050°F-1600°F (565°C-870°C) • Form: Paste • Color: White

Pioneering Industrial Sustainability

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