

# PRODUCT DATASHEET

## Meta-Braze™ AB 21 Flux Paste

Meta-Braze™ AB21 Flux Paste is a specialised silver brazing flux paste specifically formulated for use on aluminium bronze components. It demonstrates good fluxing activity on aluminium bronze other copper alloys containing 2%-10% aluminium, where conventional silver brazing fluxes do are not effective.

It has a nominal working range of 550-775°C, which can be extended to 800 °C on smaller components or with rapid heating methods. Suitable for use on aluminium bronze fittings and pipework.

### Product Details

Composition:	Proprietary
Specification / Standard:	EN 1045:1997: FH11 / ISO 18496:2021 FH11 B
Active Range:	550-775°C

### Conditions For Use

First remove surface contamination from the parts to be brazed. They should be free from oil and grease; surface oxide should be mechanically removed. Stir Meta-Braze™ AB 21 Flux Paste before use.

A layer of flux paste should be applied, using a paint brush, to the joint surfaces before assembly of the parts. Further flux should then be applied externally either side of the joint mouth and onto any braze preforms placed outside the joint. Next the parts should be heated evenly to the brazing temperature, without localised overheating. During heating the flux will bubble as water is boiled off and the flux will become opaque and then clear as the brazing temperature is reached. If the flux becomes burnt and blackened it indicates overheating or inadequate fluxing.

The flux residues of this product, left after completion of the brazing operation, are corrosive and should be removed. For best results soak the components in warm water (60°C) for approximately 30 minutes then brush residues off and rinse before drying.

Store flux at ambient room temperature with the lid on.

### Forms of Supply

1Kg plastic pots

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