

PRODUCT DATASHEET

Meta-Braze™ BM 21 Flux Powder

Meta-Braze™ BM 21 Flux Powder is a brown coloured, boron-modified flux powder specifically designed for silver brazing of tungsten carbide and PCD. The boron addition helps to improve wetting of the braze alloy onto difficult-to-wet parent materials such as tungsten carbide. This flux can also be used for brazing of cast iron.

Meta-Braze™ BM21 Flux Powder is a highly active flux with good fluidity and a medium life span.

Product Details

Composition:	Proprietary
Specification / Standard:	EN 1045:1997: FH12 / ISO 18496:2021 FH12 A
Active Range:	550-800°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.

For best results make a thick paste using Meta-Braze™ BM 21 Flux Powder, water and 2-3 drops of liquid surfactant (washing up liquid) 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 provide a smooth brown covering 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

500gm Pots

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