

PRODUCT DATASHEET

Meta-Braze™ LT 21 Flux Powder

Meta-Braze™ LT 21 Flux Powder is a general-purpose silver brazing flux powder designed for use with silver brazing alloys, in an operating temperature range of 550-800°C and using flame or induction heating processes. It is suitable for use on copper and copper alloys (brass, bronze etc.), steel (mild, carbon and stainless steel), tungsten carbide and PCD segments. This flux is suitable a wide range of silver brazing applications including making joints in HVAC&R.

Product Details

Composition:	Proprietary
Specification / Standard:	EN 1045:1997: FH10 / ISO 18496:2021 FH10 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.

Mix the powder with water and a few drops of a liquid detergent to form a paste. Then brush the paste onto the joint surfaces before assembly. Further flux should then be applied externally either side of the joint opening.

Meta-Braze™ LT 21 Flux Powder is also suitable to be applied using a 'hot-rodding' technique where flux powder is transferred to the warmed joint surfaces by dipping a warmed brazing rod in the flux powder and then wiping the flux that has adhered to the rod onto the joint opening, before heating it to brazing temperature.

Next heat the parts evenly to the brazing temperature, without localised overheating. During heating the flux will bubble as water is boiled off and the flux will become 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 / 30 mins), then brush residues off and rinse before drying.

Forms of Supply

Pots 250 gm and 500gm. Other sizes on request

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