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Brazing — Fluxes for brazing — Classification and technical delivery conditions

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Foreword

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 13, *Brazing materials and processes*.

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Brazing — Fluxes for brazing — Classification and technical delivery conditions

1 Scope

This document specifies the classification of fluxes used for brazing metals and characterizes these fluxes on the basis of their properties and use, and gives technical delivery conditions and health and safety precautions.

This document covers two classes of flux, FH and FL. Class FH is used for the brazing of heavy metals (steels, stainless steels, copper and its alloys, nickel and its alloys, precious metals, molybdenum and tungsten). Class FL is used for the brazing of aluminium and its alloys.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at http://www.electropedia.org/

4 Classification

4.1 General

The form of the fluxes shall be classified according to Table 1 A, B or C. The effective temperature range can be determined according to Annex A.

4.2 Fluxes for brazing heavy metals (Class FH)

4.2.1 General

Class FH covers nine types of flux. The code for each type consists of the class letters FH followed by two digits.

4.2.2 Type FH10

Fluxes with an effective temperature range from about 550 °C up to about 800 °C. They contain boron compounds, simple and complex fluorides and are used at brazing temperatures above 600 °C. These are general purpose fluxes. The residues are usually corrosive and have to be removed by washing or pickling.

4.2.3 Type FH11

Fluxes with an effective temperature range from about 550 °C up to about 800 °C. They contain boron compounds, simple and complex fluorides and chlorides and are used at brazing temperatures above

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