

Brazing — Fluxes for brazing — Classification and technical delivery conditions

The European Standard EN 1045 : 1997 has the status of a
British Standard

ICS 25.160.50

National foreword

This British Standard is the English language version of EN 1045 : 1997.

The UK participation in its preparation was entrusted to Technical Committee WEE/19, Brazing and braze welding, which has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

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Summary of pages

This document comprises a front cover, an inside front cover, the EN title page, pages 2 to 4, an inside back cover and a back cover.

Amendments issued since publication

Amd. No.	Date	Text affected

This British Standard, having been prepared under the direction of the Sector Board for Engineering, was published under the authority of the Standards Board and comes into effect on 15 September 1997

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ISBN 0 580 28353 4

ICS 25.160.50

Descriptors: Welding, brazing-and soldering, brazing, soldering fluxes, classifications, designations, delivery

English version

Brazing — Fluxes for brazing — Classification and technical delivery conditions

Brasage fort — Flux pour le brasage fort —
Classification et conditions techniques de livraison

Hartlöten — Flußmittel zum Hartlöten —
Einteilung und technische Lieferbedingungen

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart 36, B-1050 Brussels

Foreword

This European Standard has been prepared by Technical Committee CEN/TC 121, Welding, the secretariat of which is held by DS.

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1 Scope

This standard 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.

2 Classification

2.1 General

This standard 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.

2.2 Fluxes for brazing heavy metals (Class FH)

2.2.1 General

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

2.2.2 Type FH10

Fluxes with an effective temperature range from 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.

2.2.3 Type FH11

Fluxes with an effective temperature range from 500 °C up to about 800 °C. They contain boron compounds, simple and complex fluorides and chlorides and are used at brazing temperatures above 600 °C. These fluxes are mainly used for brazing copper-aluminium alloys. The residues are usually corrosive and have to be removed by washing or pickling.

2.2.4 Type FH12

Fluxes with an effective temperature range from 550 °C up to about 850 °C. They contain boron compounds, elemental boron and simple and complex fluorides and are used at brazing temperatures above 600 °C. These fluxes are mainly used for brazing stainless and other alloy steels and hard metals. The residues are usually corrosive and have to be removed by washing or pickling.

2.2.5 Type FH20

Fluxes with an effective temperature range from 700 °C up to about 1000 °C. They contain boron compounds and fluorides and are used at brazing temperatures above 750 °C. These are general purpose fluxes. The residues are usually corrosive and have to be removed by washing or pickling.

2.2.6 Type FH21

Fluxes with an effective temperature range from 750 °C up to about 1100 °C. They contain boron compounds and are used at brazing temperatures above 800 °C. These are general purpose fluxes. The residues are usually non-corrosive but can be removed mechanically or by pickling.

2.2.7 Type FH30

Fluxes with effective temperatures from 1000 °C upwards. They generally contain boron compounds, phosphates and silicates and are intended mainly for use with copper and nickel brazing filler metals. The residues are usually non-corrosive but can be removed mechanically or by pickling.

2.2.8 Type FH40

Fluxes with an effective temperature range from 600 °C up to about 1000 °C. They generally contain chlorides and fluorides but are boron-free and are intended for applications where the presence of boron is not permitted. The residues are usually corrosive and have to be removed by washing or pickling.

2.3 Fluxes for brazing light metals (Class FL)

2.3.1 General

Class FL covers two types of flux. The code for each type consists of the class letters FL followed by two digits. These fluxes have effective temperatures from 550 °C upwards.

2.3.2 Type FL10

These fluxes contain hygroscopic chlorides and fluorides, primarily lithium compounds. The residues are corrosive and have to be removed by washing or pickling.

2.3.3 Type FL20

These fluxes contain non-hygroscopic fluorides. The residues are generally non-corrosive and can be left on the work piece, but the joint has to be protected against water or humidity.

3 Designation

Fluxes supplied in accordance with this standard shall always be designated by the number of this standard and the flux code detailed in clause 2.

NOTE. However, for each flux code there are fluxes available commercially which behave significantly differently, e.g. in fluidity, resistance to overheating and outgassing. Therefore, in certain cases, it may be necessary to specify a flux by the trade name as well as the code details in clause 2.

Example: Designation of a flux of class FH, type FH 20 in accordance with EN 1045:

Flux EN 1045 — FH 20.

4 Technical delivery conditions

4.1 Forms of delivery

Powder, paste or liquid, brazing alloy-flux mixtures (in the form of paste or powder).

4.2 Packaging and marking

Fluxes and filler metal-flux mixtures supplied in accordance with this standard shall be packed in suitable containers resistant to the flux they contain and shall be labelled with:

- a) the supplier's name and address;
- b) the trade name;
- c) the designation in accordance with clause 3;
- d) the batch number;
- e) any hazard warning required by national or EU regulations.

5 Health and safety precautions

When working with fluxes, the following points shall be noted:

- contact with the skin, particularly if broken, shall be avoided;
- the workshop, or place where the work is carried out, should be adequately ventilated.

Attention is drawn to the need to comply with any appropriate national legislation covering the transportation, storage, use and disposal of fluxes.

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