

FONTARGEN F 300 DS 10 - DOSABLE

Dispensable brazing flux paste for automatic brazing systems (autobrazer)

FONTARGEN F 300 DS 10 is a dispensable flux paste for brazing copper, copper alloys such as brass/bronze, as well as steel and mixed joints. Pneumatic dosing valves or cartridge systems can be used for dosing. This ensures a high degree of reliability in the reproducibility of the flux quantities applied. The flux paste does not contain any SVHC substances (Substance of Very High Concern) and is therefore compliant with the current REACH regulation and is not a dangerous good in transport by water, land or air.

Product features	Product advantages	User benefits
» Flux paste	<ul style="list-style-type: none"> » Homogeneous distribution of the flux components » Very good adhesion to the joining part surface 	<ul style="list-style-type: none"> » No mixing or stirring necessary » Suitable for dosing needles with an internal diameter of at least 0.6 mm
» High proportion of active substances	<ul style="list-style-type: none"> » Very good activation of the brazing surfaces (carbide) » Effective range from 550 - 800 °C 	<ul style="list-style-type: none"> » Good activation is the prerequisite for high strength of the brazed joint » Suitable for silver brazing alloys containing manganese » Brazing Cr/Ni steels » Reduction of the applied flux quantities
» Dosing capability	» Flux application with dosing valves and cartridges	<ul style="list-style-type: none"> » Application of reproducible Flux quantities » Use in partially or fully automatic soldering systems
» Transparent flux melt	» Brazing alloy-melting and flowing visible	» Visual control
» Does not contain SVHC substances	» No dangerous goods and compliant with the current REACH regulation	» Low handling costs, such as transport and storage



Typical applications

- » Inductive brazing of pipe connections
- » Induction brazing of carbide steel joints
- » Partially or fully automatic soldering systems

FONTARGEN F 300 DS 10

Classification

EN ISO 18496

FH 10 B

Properties

Effective range (°C)	Colour	Residues	Dilution	Brazing alloys	Stir before use
550 - 800	white	Corrosive back stands must be washed or pickling be removed	Fontargen-Thinner not with dist. Dilute water	Ag brazing alloys	no

Processing instructions

Store at 20 °C in tightly sealed containers; shelf life at least 6 months in the original sealed container; avoid air inclusions in the dosing system; dilution reduces the flux effect; dosing pressure max. 3 bar

Base materials

Copper, brass, bronze, nickel alloys, hard metals, Cr/Ni steels

Soldering process

Flame soldering (brief flame formation possible), induction soldering

Product name	Shape	Quantity (kg)	Packaging
F 300 DS10	Flux paste	1,5	Sealable tin

