



Castolin 800

Powder brazing flux for copper and copper alloys

Description

The CASTOLIN 800 flux consists of a mixture of potassium complex salts, borates and fluoborates.

It is intended for capillary brazing using copper-phosphorus alloys.

Before using, read the MSDS :

<https://www.castolin.com/fr-FR/msds>

Application examples

Flux designed for the brazing of copper and copper alloys with the exception of copper-aluminium alloys. It is paired with filler metals such as:

- CASTOLIN 800 - 804 - 806 - 1803 D
- CASTOLIN RB 4242 - RB 4270 - RB 5246
- **And all other alloys** forming part of the copper-phosphorous family.

Standard mechanical and physical characteristics

Product colour	Pink
Density	0.7 g/cm ³
PH (in an aqueous solution)	8
Solubility	Water-soluble
Application temperature	500 to -800°C

UFI:WM55-WVW1-P10R-WJES

Standards

NF EN 1045	FH 10
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Instructions for use

Preparation

- If necessary, clean the joint surfaces and round off any sharp edges. Degrease the parts with an appropriate solvent. Comply with the tight fit, determined by the alloy and the nature of the parts used.
- The flux promotes the wetting of the filler metal and acts as an indicator for the bonding temperature.
- Place the parts in their definitive position. Adjust the welding torch to obtain a neutral or slightly carburising flame. Dip the pre-heated rod in the flux, which then sticks to the rod.
- Melt the flux at the joint surface. Uniformly, heat the parts to be joined up to the bonding temperature. Put the rod tip on the joint, melt a drop and spread it with a continuous movement of the flame, the alloy will be distributed to the hottest areas of the surfaces to be joined.
- Melt the filler metal until the joint has been completely filled.

Cleaning

- The Castolin flux residues can be removed either by washing with **hot water** or prolonged soaking in cold water followed by careful rinsing.
- A mechanical or chemical process can also be used.

Form of delivery

Packaging: Plastic box