



## Gas Welding Fluxes

### DESCRIPTION

ESAB welding and brazing fluxes are well known and are designed to obtain consistent and sound joints between steel, copper, brass, bronze and aluminium. Some of the common applications are found in manufacturing and repair of automobiles, refrigeration and air conditioning, tool manufacturing and other industries.

### ESAB WELDING AND BRAZING FLUXES

Flux	Application
<b>ESAB Castox</b>	Cast Iron Welding Cast Irons by fusion welding technique.
<b>ESAB Brazotectic</b>	Fusion welding of brass, brazing copper to steel sheets and tubes with Silicon Bronze rods. Welding copper alloys with Nickel Bronze and other Bronze rods. However not suitable for braze - welding cast iron or brazing stellite for tipping of tools.
<b>ESAB Bronzotectic</b>	Braze welding cast or malleable iron and building up worn bearing surfaces with Manganese Bronze rods and Nickel Bronze rods.
<b>ESAB Alotectic</b> AWS A5.31 FBI-A	Welding Aluminium and Aluminium alloys
<b>ESAB Rumatam A</b> AWS A5.31 FB3-F	For Silver Brazing
<b>ESAB Albratectic</b> AWS A5.31 FBI -A	Brazing Aluminium and Aluminium alloys containing 2% Magnesium

### REMOVAL OF FLUX RESIDUE:

**Aluminium and Aluminium alloys:** Immediately after welding wash the joints in warm water and brush vigorously. When conditions allow, follow up by a rapid dip in a 5% solution of nitric acid; wash again, using hot water to assist drying.

**Copper and Brass:-** Wash in boiling water followed by brushing. Where possible a 2% solution of nitric or sulphuric acid is preferred to help in tipping the glassy deposit, followed by a hot water wash.

**Cast Iron:-** Residues may be removed easily by a chipping hammer or wire brush.

**Rumatam A:-** Can be easily removed by soaking brazed components in hot water followed by wire brushing. In difficult situations, the work piece should be immersed in 5% to 10% sulphuric acid solution for a period of 2 to 5 minutes, followed by hot water rinsing and wire brushing.

**PACKING:** ESAB Welding and Brazing Fluxes are packed in plastic containers and then in cardboard box totalling 25 Kg Net of 500g each.