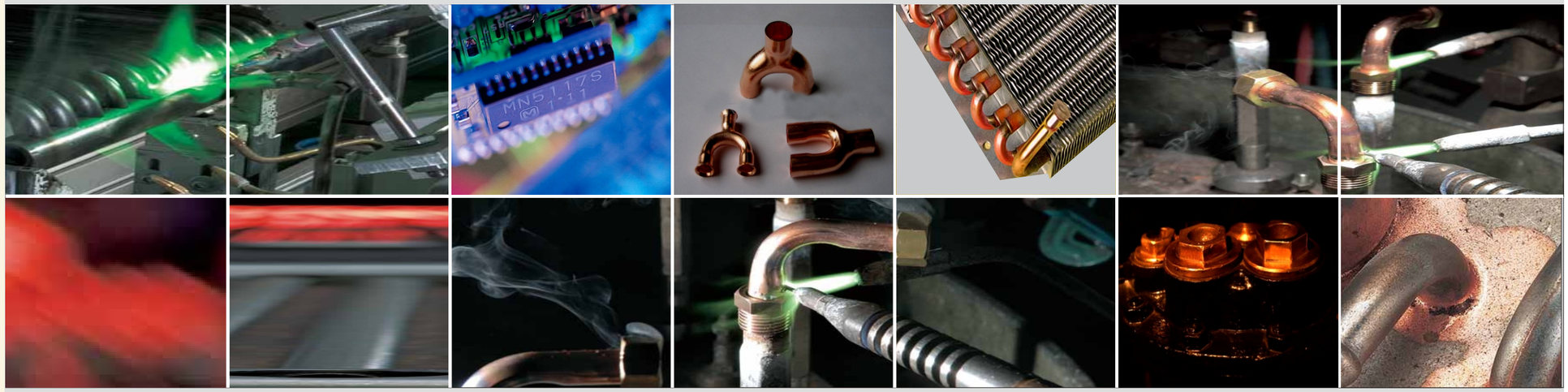
华中 HUAZHONG

中山市华中金属焊料有限公司

Zhongshan Huazhong Metal Brazing Materials Co.,Ltd



Headquarters: Zhongshan Huazhong Metal Brazing Materials Co., Ltd

Address: Ma'an Industrial Zone, Huangpu, Zhongshan, Guangdong, China
Telephone: +86-0760-23224228 23224229 +86-18125214120
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Email: sales@huazhong-brazing.com max@huazhong-brazing.com
Website: https://www.huazhong-brazing.com

JIEHAO

Branch Office: Foshan Jiehao Metal Co., Ltd

Address: Xiaohuangpu, Ronggui, Shunde, Foshan, Guangdong, China
Tel/Fax:+86-0757-23617068

钎焊材料使用手册

BRAZING MATERIALS APPLICATION MANUAL

https://www.huazhong-brazing.com

公司简介
COMPANY INSTRUCTION



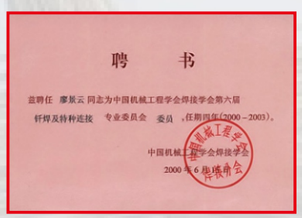
华中金属焊料有限公司是生产钎焊材料的专业企业、中国焊接学会团体会员单位和国家钎焊标准化技术委员会委员单位。公司占地面积10000多平方米、拥有标准工业厂房6000多平方米，具有年产1500吨各种优质钎焊材料及钎焊助剂的生产能力。

华中金属焊料有限公司是集钎焊材料技术研发、生产、推广应用、技术服务于一体的科技型企业。公司科研实力雄厚，除与国内多家大学和科研机构进行合作外，还与意大利A.V.Saldature s.r.l.公司进行全面的技术合作和新产品的研发和推广应用。公司产品主要有银钎料、铜基钎料、锡基钎料、铝基钎料四大系列，包括各种规格焊条（棒）、焊丝、焊片、成型焊环（园型环、方型环、不规则异型环）、还有粒状、粉状、膏状等钎料材料及配套钎焊助剂等四大系列数百个品种的优质钎焊料产品。是目前中国钎焊材料同行中规模较大、品种最多、规格最齐全、钎焊技术力量及服务能力最强的企业之一。

公司在中国市场钎焊料销售和技术推广应用方面有十多年的经验，产品除销往国内的电冰箱、空调器、冷柜、热水器等产品的热交换器和管路焊接，以及电发热管、变压器、电机电器、汽车配件、自行车、金属家具、仪器仪表、灯饰、首饰、不锈钢壶及装饰制品等行业以外；还有出口到欧洲、美国、东南亚等国家和地区。









公司简介
COMPANY INSTRUCTION

Huazhong Metal Brazing Materials Co., Ltd is a professional manufacturer of brazing materials, a member of China Welding Academic Society and National Brazing Standard Technologies Committee.The company occupies a territory of more than 10000M^2 and plant premises of 6000M^2, with an annual production capacity of 1500 ton different brazing materials and de-oxidant at high quality.

Huazhong Metal Brazing Materials Co., Ltd is a technical oriented company combining all functions of R&D, production, application and technical service. We have very strong technical research abilities; besides of continuous cooperation with various universities and R&D institute in China, we also established long-term partnership with Italy AV Saldature s.r.l. for new products development and application. Our products range includes 4 main series: silver alloy, copper alloy, tin alloy and aluminum alloy; all kinds of alloy can be processed into brazing rods, wires, plates, rings, powder or even paste, and we can match them with suitable de-oxidants. Therefore we are considered as one of the most competitive companies in aspects of factory dimension, products range, brazing technologies and service capabilities.

The company has more than 10years of successful experiences, till today our products was applied in heating exchangers & tubes of refrigerators, air-conditioners, water heaters, and heating elements, transformers, motors, automobile components, bicycles, metal furniture, measuring appliances, lamps, stainless steel products; what's more, we export to Europe, America and Southeast Asia.







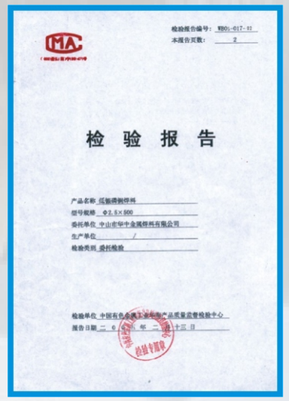
检测报告
TEST REPORT

产品成分与性能检测报告
Chemical Composition and Features Test Report


检 验 报 告

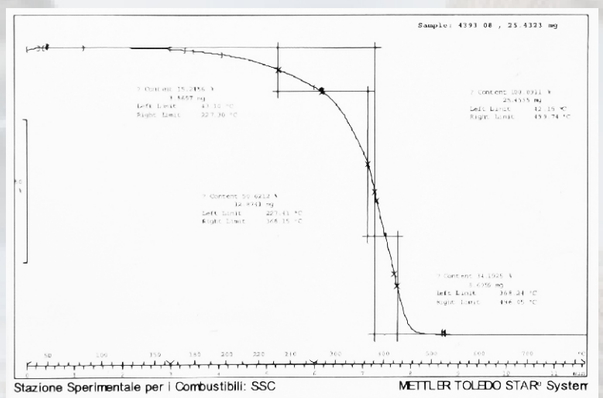

检 验 报 告 书


检 验 报 告 书


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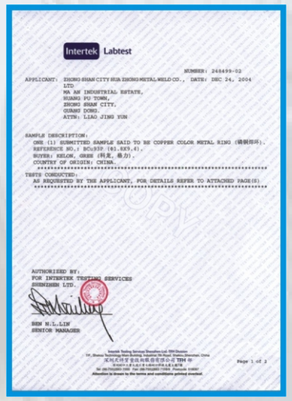

检 验 报 告 书


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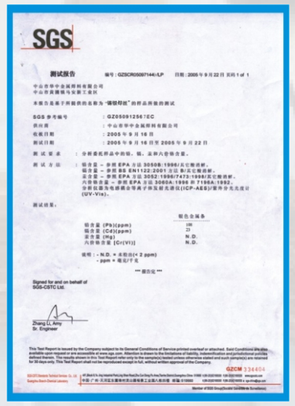


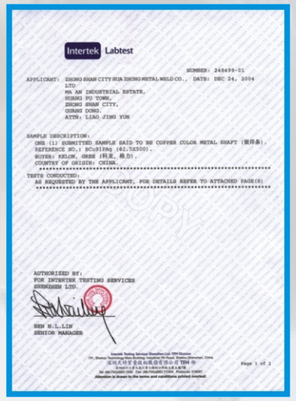

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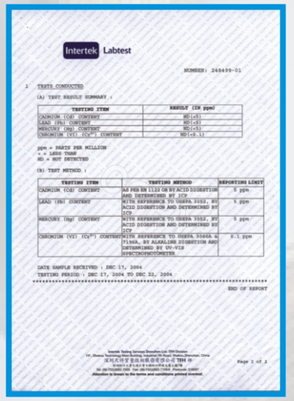
欧盟ROSH指令要求检测报告
The European ROSH Standard Related Test Report

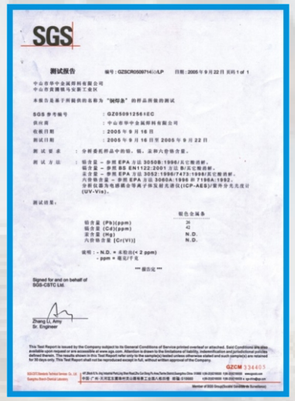

Intertek Labtest

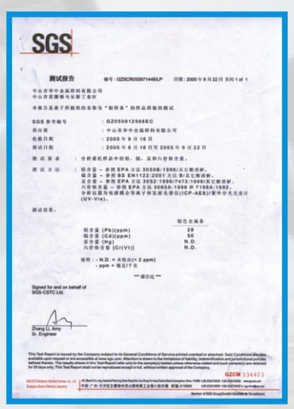

Intertek Labtest

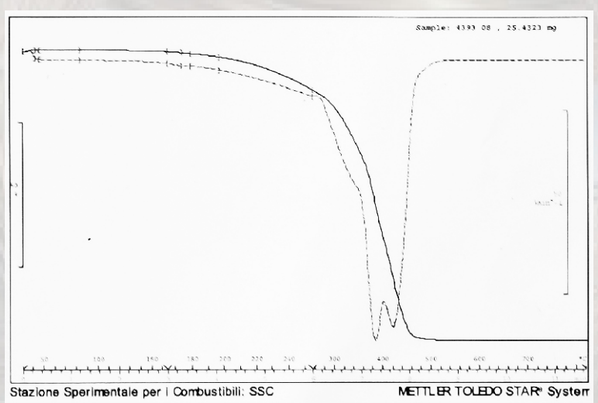

SGS


Intertek Labtest


Intertek Labtest


SGS


SGS





华中 HUAZHONG
产品篇
PRODUCTS



铜基钎料 Copper-Based Brazing Alloy

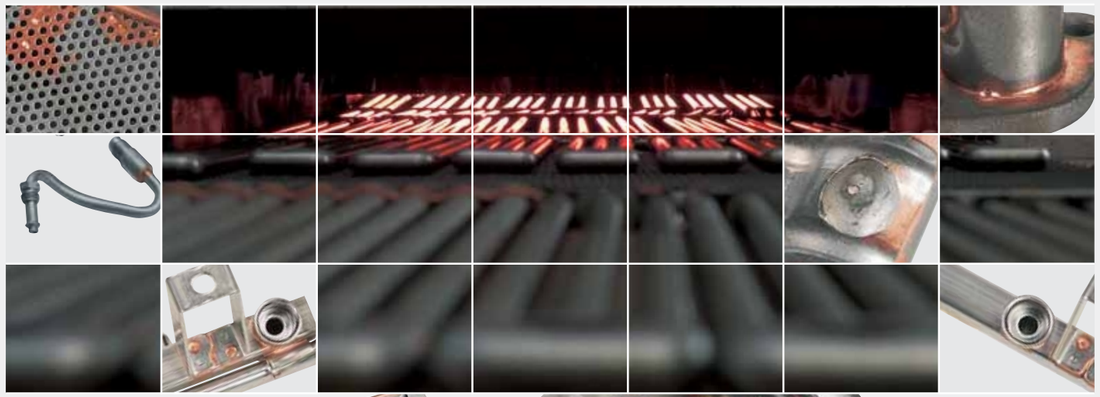
产品系列 Product Series	产品型号 Product Number	相关标准 Related Standard	化学成分 Chemical Composition (%)				熔化温度 Melting Range (℃)	焊接温度 Working Temperature(℃)	特点 Characteristics	应用 Application
			Cu	P	Ag	Other				
磷铜钎料 Phosphorus Copper Brazing Alloy	BCu95P	AWS BCuP-1	rem.	4.8-5.3			778-924	788-927	Low melting temperature, good flowability, good ductility and capillary filling capability. Suitable for gap filling brazing situation.	Primarily used for brazing pure copper and copper alloy, with application including refrigeration, air conditioning, gas appliances, heat exchangers, and plumbing fixtures(depends on specific base material). No flux is needed when brazing pure copper substrates. Not suitable for iron based or nickel based alloys, or copper-nickel alloys with a nickel content exceeding 10%. They can be produced in rods, wires, rings, sheets. Not suitable for jointing components involved in high frequency of vibration, impact, or bending.
	BCU94P		rem.	5.9-6.5			750-880	743-840		
	BCu93P	AWS BCuP-2 China HL202	rem.	6.6-7.4			710-800	743-840		
	BCu92P	China HL201	rem.	7.5-8.1			710-780	730-830		
磷铜锡钎料 Phosphor-Copper-Tin Brazing Alloy	BCu86PSn	China HL208	rem.	6.4-7.2		Sn:6.5-7.5	640-680	700-750	Low melting temperature, excellent flowability and wettability, good capillary filling ability, good conductivity.	This series of alloy is widely used for brazing brass-brass, copper-brass, and copper alloy. For brazing brass and bronze, it is recommended to use a flux for better wetting properties. Not suitable for brazing carbon steel, stainless steel, nickel alloys, or iron-based materials. It is also unsuitable for joints subject to high vibration, stainless steel parts, or parts subjected to impact loads. Applications include air conditioning valves, HVAC, gas valves, electrical and power industries, lighting fixtures, and other hardware and general machinery (specific applications depend on the base material). They can be produced in rods,
	BCu90PSn		rem.	6.3-7.0		Sn:2.0-4.0	650-700	710-760		



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BRAZING ALLOYS

铜基钎料 Copper-Based Brazing Alloy

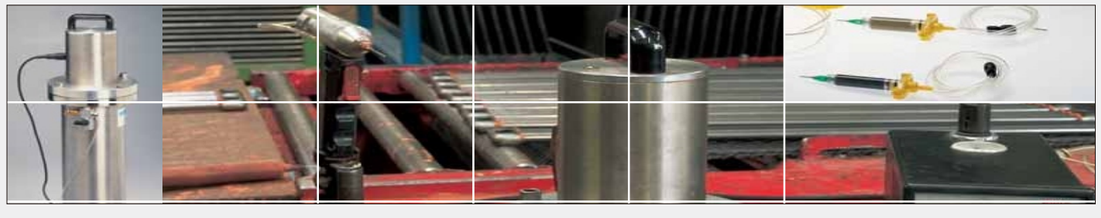
磷铜银钎料 Phosphor-Copper-Silver Brazing Alloy	BCu92PAg		rem.	5.9-6.7	1.5-2.5		645-780	740-810	High-silver class (above 10%) results in a narrower melting range and lower liquidus temperature, simultaneously improving wettability, capillary filling ability, joint toughness, and vibration resistance. Low silver content (below 10%) leads to lower costs.High silver increases toughness, while low silver decreases it. It possesses excellent electrical conductivity. Compared to phosphor-copper brazing filler metal (silver-free), the addition of silver reduces brittleness,improves corrosion resistance, and joint reliability.	Silver-containing phosphor copper brazing alloy can be used for brazing base materials of copper and copper alloys, but it is not suitable for brazing carbon steel, stainless steel, and nickel alloys. Applications include refrigeration and HVAC, gas appliances, plumbing and sanitary ware, electrical power, general machinery, and instrument hardware. Can be customized in rods, wires, rings, and sheets.
	BCu91PAg	Japan BCuP-6 China HL209	rem.	6.8-7.2	1.8-2.2		643-778	730-810		
	BCu89PAg	AWS BCuP-3 China HL205	rem.	5.8-6.2	4.8-5.2		643-843	705-850		
	BCu90PAg		rem.	6.5-7.3	2.8-3.2		643-843	710-850		
	BCu88PAg	AWS BCuP-7	rem.	6.5-7.0	4.8-5.2		643-843	705-850		
	BCu87PAg	AWS BCuP-4	rem.	7.0-7.5	5.8-6.2		645-725	705-780		
	BCu80PAg	AWS BCuP-5	rem.	4.8-5.2	14.5-15.5		643-802	704-810		
	BCu75PAg		rem.	6.6-7.5	17.0-19.0		640-670	704-810		





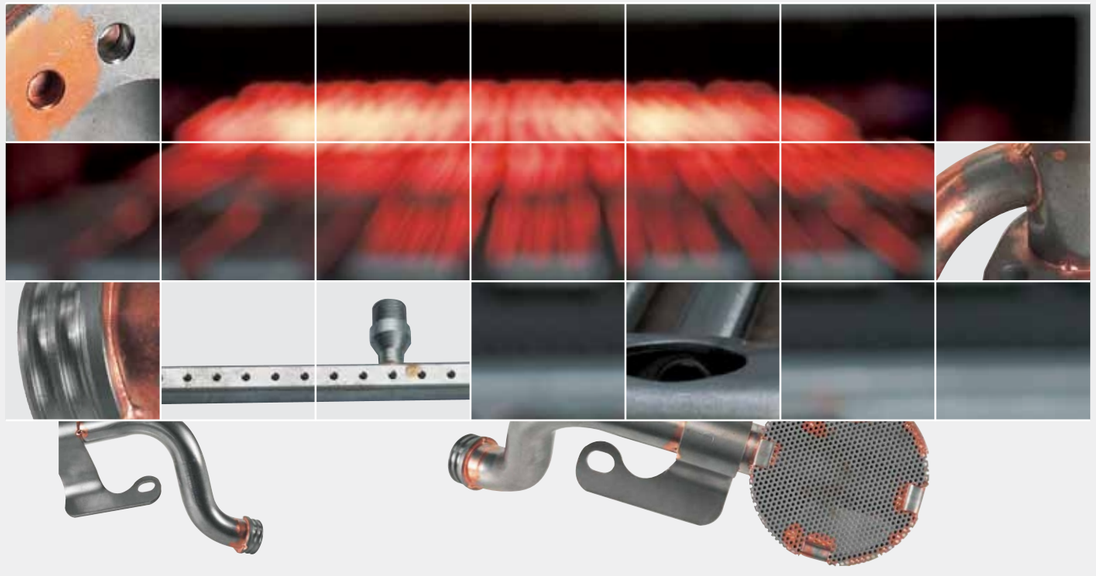


铜基钎料 Copper-Based Brazing Alloy										
产品系列 Product Series	产品型号 Product Number	相关标准 Related Standard	化学成分 Chemical Composition (%)				熔化温度 Melting Range (℃)	焊接温度 Working Temperature(℃)	特点 Characteristics	应用 Application
			Cu	P	Ag	Other				
铜钎料（紫铜、纯铜） Copper Brazing Alloy	BCu(Cu-1)	AWS BCu-1	≥99.5				1083	1093-1149	It exhibits high strength, excellent heat resistance, excellent ductility and toughness. The joint demonstrates excellent impact and vibration resistance, superior electrical and thermal conductivity, and corrosion resistance. It also exhibits good wettability to carbon steel, low-alloy steel, and stainless steel, and can be brazed to hard alloys.	This type of brazing filler metal is suitable for brazing base materials such as carbon steel, low alloy steel, stainless steel, cemented carbide, and nickel-based alloys. it is suitable for vacuum brazing and protective atmosphere furnaces. Applications include industrial panel heat exchangers, cemented carbide tools, molds, automotive industry, engineering machinery, and aerospace. Wires, rods, rings can be made as required.
铜锌钎料（黄铜） Copper-Zinc Brazing Alloy	BCu62Zn	China HL104	61-63	rem.		Mn、Si	850-875	910-954	Cu-Zn based brazing alloy must be used with brazing flux. It can be brazed with steel, cast iron, cemented carbide, and copper alloys. It produces high-strength joints with good mechanical properties. The addition of Mn, Si, Sn, and Fe alloying elements improves wetting, crack resistance, and reduces smoke emissions respectively.	This type of brazing alloy can be brazed with steel, cast iron, copper, nickel-based metals, and cemented carbide, makes the steel-copper dissimilar metal brazing possible. It is not suitable for highly corrosive environments and is not recommended for stainless steel (poor wetting, silver-based brazing alloys are preferred for stainless steel). It is available in a full range of processing forms: straight brazing rods, wires, and some grades can be made into flux-coated welding rods. It is suitable for gas flame brazing and high-frequency induction brazing. Applications include cemented carbide tools, steel-copper dissimilar joints in general machinery and hardware, cast iron valves, and the repair industry.
	BCu58ZnMn	China HL105	57-59	rem.		Mn、Fe	880-909	910-954		
	BCu60ZnSn	AWS BCuZn-A China HL201	59-61	rem.	0.8-1.2	Mn、Si	850-875	910-954		
	BCu59ZnSn	EN 1044-Cu306	58-60	rem.	1	Mn:0.8、Si	880-900	910-954		

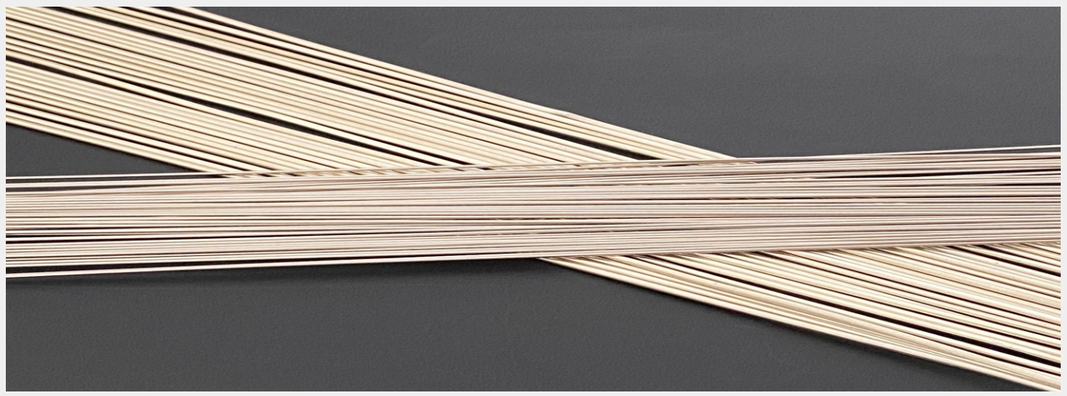


华中 HUAZHONG
钎焊材料篇
BRAZING ALLOYS

铜基钎料 Copper-Based Brazing Alloy										
产品系列 Product Series	产品型号 Product Number	相关标准 Related Standard	化学成分 (%)				熔化温度 Melting Range (℃)	焊接温度 Working Tempreture(℃)	特点 Characteristics	应用 Application
			Cu	Zn	Ni	Other				
铜镍钎料(白铜) Copper-Nickel Brazing Alloy	BCu51ZnNi		50-52	rem.	10	Si	921-935	938-982	All products must be used with flux and are suitable for gas flame brazing and induction brazing. Nickel significantly improves joint strength, corrosion resistance, and fatigue resistance. Zinc volatilization is much lower than ordinary brass brazing alloy. It exhibits good wetting properties on carbon steel, cast iron, copper alloys, nickel-based alloys, hard alloys, and some stainless steels. It enables brazing of dissimilar materials like steel and copper. Compared to silver-based brazing alloy, it has a significant cost advantage and can replace some silver alloy to reduce costs. It is not suitable for strong acid and corrosion conditions. Higher nickel content results in better corrosion resistance and fatigue resistance, and a higher melting point.	Widely used in the high mechanical strength cemented carbide cutting tool industry: brazing of drill bits, saw blades, lathe tools and other cutting heads to steel substrates. Engineering machinery, hydraulic system parts. Valves and pipe fittings in the refrigeration and pump valve industries. Carbon steel, copper, nickel alloy and some stainless steel components, steel-copper dissimilar joints. Suitable for parts that are subjected to alternating loads and work in slightly corrosive environments.
	BCu57ZnNi		56-58	rem.	5	Si	870-910	910-960		
	BCu50ZnNi	EN 1044-Cu305	49-51	rem.	9	Si:0.1	921-935	938-982		

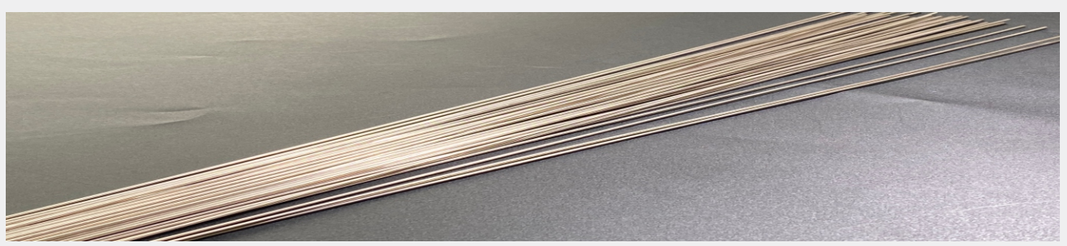


无镉银基钎料 Silver-Based Brazing Alloy without Cadmium											
产品系列 Product Series	产品型号 Product Number	相关标准 Related Standard	化学成分 Chemical Composition (%)					熔化温度 Melting Range (℃)	焊接温度 Working Temperature(℃)	特点 Characteristics	应用 Application
			Ag	Cu	Sn	Zn	Other				
低银钎料 Low-Silver Component Brazing Alloy	BAg2CuZnSn		1.5-2.5	54-56	1.5-2.5	rem.		790-830	830-900	Low-silver class brazing alloy requires to use with the appropriate flux and has no self-brazing properties. Its low silver content offers a significant cost advantage compared to high-silver class brazing alloys. It exhibits superior wetting and fluidity compared to brass/Cu-Ni brazing filler metals. It can be brazed with carbon steel, copper alloys, nickel alloys, and cemented carbide, and some grades can be brazed with stainless steel. It provides good joint strength and ductility. Its melting temperature is relatively high. It is not suitable for vacuum brazing. Total impurity content is ≤ 0.15.	Widely used in hardware tools, carbide cutting tools, refrigeration parts, electrical instruments, low-pressure valves and pipelines, carbon steel-copper dissimilar joints. Mass production cost reduction and replacement of high-silver brazing filler metal. Suitable for flame brazing and induction brazing. Can be made into wires, rods, rings, and sheets according to customer needs. Meeting EU RoHS standards and can be used for brazing products or workpieces with RoHS requirements.
	BAg5CuZn	EN1044 Ag208	4.0-6.0	54-56		rem.		830-870	870-970		
	BAg5CuZnSn		4.0-6.0	54-56	1.5-2.5	38-42		830-870	870-970		
	BAg10CuZn	China HL301	9.0-11.0	52-54		35-39		815-850	850-950		



华中 HUAZHONG
钎焊材料篇
BRAZING ALLOYS

无镉银基钎料 Silver-Based Brazing Alloy without Cadmium											
产品系列 Product Series	产品型号 Product Number	相关标准 Related Standard	化学成分 Chemical Composition (%)					熔化温度 Melting Range (℃)	焊接温度 Working Temperature(℃)	特点 Characteristics	应用 Application
			Ag	Cu	Sn	Zn	Other				
高银钎料 High-Silver Component Brazing Alloy	BAg15CuZnSn		14-16	44-48	1.5-2.5	rem.		750-780	800-870	This series requires the use of flux and lacking self-brazing capability. It features a wide range of silver content, excellent wettability, fluidity, and gap-filling ability, resulting in superior ductility, strength, and impact resistance. Adding Sn significantly lowers the melting temperature and improves spreading fluidity. Adding Ni enhances wettability on stainless steel and cemented carbide, improving corrosion resistance and crack resistance. Adding Mn strengthens cemented carbide joints and inhibits crack formation. BAg72Cu is a silver-copper eutectic brazing filler metal with a fixed melting point of 779℃ and excellent fluidity. Suitable for flame brazing, induction brazing, and furnace brazing. Not suitable for vacuum brazing. Higher silver content results in a lower melting range and better fluidity and plasticity.	Widely used in brazing stainless steel, carbon steel, copper and copper alloys, nickel-based alloys, and cemented carbide cutting tools, refrigeration and air conditioning pipes, compressors, and valves, hydraulic and pneumatic components, electrical appliances, instruments, and sensors, medical devices, and hardware tools. Suitable for brazing dissimilar metals such as steel-copper, steel-stainless steel, and cemented carbide-steel. Primarily used for components subjected to vibration, impact, and moderate corrosion, covering mid-to-high-end precision mass production. We can manufacture wires, rods, rings, and sheets according to customer requirements. Meets EU RoHS standards and can be used for brazing products or workpieces with RoHS requirements.
	BAg18CuZnSn	China HL309	17-19	44-48	1.5-2.5	rem.		780-810	810-920		
	BAg20CuZn	En1044 Ag206	19-21	42-47		rem.		690-795	800-900		
	BAg25CuZn	China HL302	24-26	40-42		rem.		700-800	800-890		
	BAg25CuZnSn	En1044 Ag108	24-26	39-41	1.5-2.5	rem.		700-800	800-890		
	BAg30CuZnSn	China HL302 EN1044 Ag107	29-31	35-37	1.5-2.5	rem.		650-750	740-840		
	BAg34CuZnSn	En1044 Ag106	33-35	34-38	2.5-3.5	rem.		630-730	730-840		
	BAg40CuZnSn	China HL322	39-41	29-31	1.5-2.5	rem.		634-640	640-740		
	BAg45CuZn	China HL303 EN1044-Ag203 AWS BAg-5	44-46	29-31		rem.		665-745	745-845		
	BAg45CuZnSn	EN1044-Ag104	44-46	26-28	2.0-3.0	rem.		640-680	680-780		
	BAg56CuZnSn	China HL316 EN1044-Ag102 AWS BAg-7	55-57	22-24	4.5-5.5	rem.		620-650	650-760		
	BAg55CuZnSn	En1044-Ag103	54-56	20-23	4.0-5.0	rem.		630-650	650-760		
	BAg73CuZn		72-74	15-17		rem.		635-680	680-780		



含镉银基钎料 Silver-Based Brazing Alloy with Cadmium

产品系列 Product Series	产品型号 Product Number	相关标准 Related Standard	化学成分 Chemical Composition (%)					熔化温度 Melting Range (℃)	焊接温度 Working Temperature (℃)	特点 Characteristics	应用 Application
			Ag	Cu	Zn	Cd	Other				
低银钎料 Low-Silver Component Brazing Alloy	BAg5CuZnCd		4.0-6.0	50-55	rem.	6.0-8.0		770-820	820-920	Must be used with silver brazing flux and it has no self-fluxing property. It has a moderate melting range, and its flowability and gap-filling ability are superior to cadmium-free silver brazing alloy of the same silver content. Low silver class is more cost-effective, and the brazed joint possesses good ductility and toughness. However, it has an average corrosion resistance and it is not suitable for high-vibration, impact, or corrosive environment. It is not for the use in food production and medical components.	Primarily used in applications where RoHS compliant environmental requirements are not required. Mainly used for brazing carbon steel, copper, brass, and copper-steel dissimilar metal joints.Widely used in general pipe fittings, plumbing hardware, general tools, low-voltage electrical connectors, and general refrigeration components. Suitable for flame brazing and induction brazing. Not suitable for vacuum brazing
	BAg10CuZnCd		9.0-11.0	46-50	rem.	8.0-12.0		760-810	810-910		
高银钎料 High-Silver Component Brazing Alloy	BAg12CuZnCd		11.0-13.0	40-42	rem.	10.0-14.0		750-800	800-900	Must be used with appropriate flux. Does not have self-fluxing properties. Lower overall melting range, excellent spreading, wetting, and gap-filling performance. With increasing silver content, brazed plasticity, tensile strength, and impact resistance all improve. Better mechanical properties. Can withstand vibration and impact.	Designed for mid-to-high-end applications, this brazing alloy is suitable for carbon steel, copper alloys, stainless steel, nickel alloys, and carbide cutting tools. Applications include refrigeration compressor parts, hydraulic and pneumatic components, hardware tools, and electrical switch connectors. It can be brazed with dissimilar metals such as steel-copper, steel-stainless steel, and carbide-steel. Brazing can be performed by flame, induction, or furnace brazing, but not vacuum brazing.
	BAg15CuZnCd		14-16	42-44	rem.	14-16		745-800	800-880		
	BAg18CuZnCd		17-19	36-40	rem.	15-19		740-780	790-880		
	BAg20CuZnCd	EN1044-Ag309	19-21	39-41	rem.	13-17		705-780	800-870		
	BAg21CuZnCd	EN1044-Ag308	20-22	34-36	rem.	16-18		620-730	730-830		
	BAg25CuZnCd		24-26	29-31	rem.	16.5-18.5		680-780	780-850		
	BAg30CuZnCd	China HL311 EN1044-Ag306 AWS BAg-2a	29-31	27-29	rem.	19-23		650-750	740-840		
	BAg35CuZnCd	China HL314 EN1044-Ag305 AWS BAg-2	34-36	25-27	rem.	17-19		605-700	700-845		
	BAg40CuZnCd	China HL312 EN1044-Ag304 AWS BAg-4	39-41	18-20	rem.	18-22		595-605	605-705		
	BAg45CuZnCd	EN1044-Ag302 AWS BAg-1	44-46	14-16	rem.	23-25		620-690	620-760		



华中 HUAZHONG
钎焊材料篇
BRAZING ALLOYS

无铅锡基钎料 Lead Free Tin-Based Solder

产品系列 Product Series	产品型号 Product Number	化学成分 Chemical Composition (%)					熔化温度 Melting Range (℃)	焊接温度 Working Temperature (℃)	特点 Characteristics	应用 Application
		Sn	Sb	Cu	Ag	Other				
无铅锡基钎料 Lead Free Tin-Based Solder	S-Sn	≥99	Small Amount			Sb	232	230-280	The appropriate flux must be used during application. It covers various alloy combinations including pure tin, tin-copper, tin-antimony, tin-silver, and tin-silver-antimony. The tin-copper and tin-antimony grades exhibit good high-temperature resistance and excellent high-temperature creep resistance. The tin-silver alloy demonstrates excellent wetting and spreading properties, resulting in high solder joint strength and good ductility. The overall melting temperature is higher than traditional leaded solders, making it suitable for manual soldering, wave soldering, dip soldering, and flame soldering, but not for vacuum soldering. Strict control of lead impurity content ensures it meets environmental export requirements for global markets such as the EU and North America.	Lead-free tin-based solder contains no lead or cadmium, meets environmental protection requirements, and complies with EU RoHS standards, making it suitable for brazing in the food industry. Applications include food processing, chemical manufacturing, air conditioning and refrigeration, general engineering, microelectronics, home appliances, pipe fittings, and other building equipment installation. It is suitable for brazing stainless steel, copper, and copper alloy food containers.
	S-Sn97Cu	rem.		2.5-3.5			235-245	240-290		
	S-Sn92CuSb	rem.				Cu、Sb	250-300	300-350		
	S-Sn95Sb	rem.	4.0-6.0				232-240	230-280		
	S-Sn98Ag	rem.	Small Amount		1.5-2.5	Sb	220-228	230-280		
	S-Sn97Ag	rem.	Small Amount		2.5-3.5	Sb	221-230	230-280		
	S-Sn96Ag	rem.		Small Amount	3.5-4.5	Cu	221-230	230-280		
	S-Sn95Ag	rem.	Small Amount		4.5-5.5	Sb	250	250-300		





钎焊膏
Brazing Paste

产品系列 Product Series	产品型号 Product Number	产品名称 Product Name	化学成分 Chemical Composition (%)						特点 Characteristic	应用 Application
			Cu	Al	Ni	P	Sn	Other		
钎焊膏 Brazing Paste	CuM1-ws	铜焊膏 Copper Brazing Paste	≥99.5						High-temperature brazing paste. Removes oxide from copper and iron surfaces. Residue can be easily removed, and it has good flowability. Suitable for brazing in vacuum and protective atmosphere furnace.	Furnace brazing for steel and iron workpieces. Brazing temperature between 1090-1120℃
	FH55	磷铜锡焊膏 Phosphor-Copper-Tin Brazing Paste	84-88					P、Sn	This flux paste is specifically developed for phosphor-copper alloy. Working temperature is 700-750℃. It can assist in wetting copper materials without the need for silver flux. It has low corrosion and the residue. Residue is easy to wash off with water.	Suitable for flame brazing, resistance brazing, high-frequency brazing, and furnace brazing between various copper and copper alloys. Applicable to brazing of copper-copper or copper alloys as the base material.
	AlSi-1	铝焊膏 Aluminum Brazing Paste		86-89				Si	Working temperature 580-620℃. It removes aluminum alloy oxide film. Suitable for aluminum-silicon brazing filler metal. Residue is corrosive after brazing, must be removed by water after brazing.	Suitable for brazing aluminum alloys and stainless steel in gas-protected (nitrogen or ammonia decomposition) furnaces, as well as flame brazing. Aluminum brazing paste is an ideal alternative for brazing the bottom of all-aluminum alloy automotive radiators and for brazing aluminum alloy, copper alloy, stainless steel, and stainless steel electric hot pots, frying pans, coffee makers, kettles, and other related products, as well as for brazing aluminum heating tubes.
	ST125	锡焊膏 Tin Brazing Paste					96-98	Cu	Tin soldering flux (for tin-based solders). Medium to low temperature, working temperature 220-320℃. ST125 has strong activity, ST130 has mild activity. Improves the spreading and wetting of tin-based solders. Residue is corrosive after soldering, cleaning is recommended after soldering. Compatible with lead-free tin-based solders.	Suitable for soldering copper and copper alloys, steel, stainless steel, zinc and galvanized iron sheets. Used for soldering electronic circuit boards, copper and copper alloys, steel and stainless steel products.
	ST130							Ag:3.5		







华中 HUAZHONG
金属钎焊料膏篇
BRAZING ALLOYS IN PASTE

助焊剂 Brazing Flux

产品系列 Product Series	产品型号 Product Number	相关标准 Related Standard	产品名称 Product Name	特点 Characteristic	应用 Application
助焊剂 Brazing Flux	D4	EN1044-FH12	银钎焊粉 Silver Brazing Powder	It does not absorb moisture and will never clump. It is highly active and can effectively remove oxides from various metal surfaces, promoting flowability. It has a low activation temperature and a wide range of applications.	With a melting point of approximately 550℃, it is used as a flux for brazing copper and copper alloys, steel and stainless steel in the range of 600-850℃ when combined with silver brazing filler metal.
	D26	EN1044-FH12			
	D20				
	DK		银钎焊膏 Silver Brazing Paste	It has extremely high activity, effectively removing oxides from various metal surfaces and promoting flowability. It has a neutral pH value, minimizing harm to the environment.	A flux with a melting point of 550℃, used with silver brazing alloy for brazing copper and copper alloys, steel and stainless steel in the 600-850℃ range.
	112P				
	B-1		B型锡银焊水 Tin-Silver Alloy Brazing Flux Type B	It has strong activity and can effectively remove oxides from various metal surfaces, promoting flowability.	It can be used with tin-based solders for soldering copper and copper alloys, steel and stainless steel within a working temperature range of 150-350℃.







