

	<h1>TECHNICAL DATA SHEET</h1>	Realease	1 05.5.2022
		Nature of mod.	Norm change
		Author	RQ
		Mod	CPO/ST Rev.2 del 17/06/2019

Code	Description	ISO 18496:2020	Working temperature (°C) ¹
DL87N DL87NSP DL86N DLXN	LIQUID FLUX	FH21	700-1100

Characteristics / Applications:

Colour: white

Density: powder g/cm³
paste g/cm³

This group of liquid brazing flux includes medium concentrate flux in the flame brazing flux for high temperature alloy such brass or copper phos, it has long range of use, a low fluidity, there are no residuals but you can wash the joint if necessary.

The different concentration among this fluxes are studied to achieve the best solution for each application

Recommended alloys

it can be use with all the brass based alloys (ST22 SM23 S21) to join carbon steel/copper; it can be used as a protective flux with copper Phos alloy on copper to copper joints.

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 18496:2020

Availability²

Powder (A)	Paste (B)	Dosing paste(B)	Liquid(C)	Liquid for flame flux (C)	Gel(B)
				X	

¹ According Annex A ISO 18496:2020

² See table 1 ISO 18496:2020