

	<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
DL89N DL90N DL88N	LIQUID FLUX	FH21	700-1100

Characteristics / Applications:

Colour: transparent

Density: liquid 0,8 kg/dm³

The DL89N is an high concentrate flux in the flame brazing flux for high temperature alloy such brass and Ni brass, it has long range of use, a low fluidity , there are almost no residuals and they are not corrosive, wash it if necessary.

The DL88N and DL90N are similar but less concentrate and can be used to reduce the residuals

Recommended alloys

it can be use with all the brass based alloys (ST22 SM23 SN32 SN34 SN36) and low contain silver alloy (T28 T29 T68) to join carbon steel/carbon steel or 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