

# ferrinox® 4000 FLUXING AGENT



## Our fluxing agent – developed especially for stainless steel

With registered trade name “**ferrinox®4000 Lötwasser**” we distribute a soldering fluid with standard 1.1.3 according to DIN EN 29 454-1. To braze stainless steel we recommend the use of usual 30% bar tin (S-Pb 70 su according to DIN EN 49453). If the brazing seam has to be attuned to tinned stainless steel, the processor should make use of a 99,99% tin soldering fluid, DIN 1704. The cleaning of the soldering seam should be effected with clear water or our cleaning agents (dont use for tinned-stainless steel!). For an assured compliance with the brazing fit we recommend our stainless steel riveted bolts which are also available especially for stainless steel.

## Brazing index for roof covering and roof drainage systems of stainless steel

Among craftsmen circles rustproof stainless steel has the reputation to be difficult to braze. This impression came into existence, because employees often just worked with the present soldering fluid or fluxing agent, also if it was produced for work with other materials like zinc and copper. Those fluids are unqualified for rustproof stainless steel. Especially in case of using fluxing agent that contains hydrochloric acid or chlorides, corrosion damages can occur.

## Brazing of rustproof stainless steel

Among roofer and plumber circles there are often questions about the brazeability of antirust steeltypes. The necessary knowledge for brazing of rustproof stainless steel is easy to learn. The main reason for a perfect result is the employment of a perfect soldering fluid like **ferrinox®4000** from BRANDT. As already mentioned in the introduction it is very important not to use chlorous or inappropriate fluxing agent. Soldering fluids that are generally used for processing zinc and copper are unsuitable for stainless steel. There are even fluxing agents which are said to be qualified for stainless steel and after a few years, the soldering seam comes undone and the visual appearance changes.

These fluxing agents should only be used after exact investigations. We want to point out that the **ferrinox®4000** soldering fluid ran through a lot of long run analysis and offers best results. Furthermore our experience shows that 30% tin plumb line with melting temperature between 215 and 250 degrees or high purity zinc with a fusion point of approximately 230 degrees should be employed if the visual appearance of the soldering seam has to meet highest expenses.



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