

TECHNICAL DATA SHEET

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 $(^{\circ}C)^{1}$
D54M D54MD	D54 PASTE FLUX	FH21	700-1100

Characteristics / Applications: Colour: white Density: powder g/cm³ paste g/cm³

The D54 is a brazing flux for high temperature alloys such brass and Ni brass brazing alloys, it has long range of use, a low fluidity and a very high heating resistance, the residuals are not corrosive but can be removed by washing or picking.

Recommended alloys

it can be use with all the brass based alloys (ST22 SM23 SN32 SN34 SN36)

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)
	Х	Х			

¹ According Annex A ISO 18496:2020

² See table 1 ISO 18496:2020

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