

	<b>TECHNICAL DATA SHEET</b>	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) <sup>1</sup>
D54M D54MD	D54 PASTE FLUX	FH21	700-1100

**Characteristics / Applications:**

Colour: white

Density: powder g/cm<sup>3</sup>  
paste g/cm<sup>3</sup>

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**

**Availability<sup>2</sup>**

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

<sup>1</sup> According Annex A ISO 18496:2020

<sup>2</sup> See table 1 ISO 18496:2020