

# TECHNICAL SHEET

## Flux AG4

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**STELLA**  
WELDING ALLOYS

**Product name**

AG4

**Class of product**

Brazing Flux

**Corresponding standards**

DIN8511 F-SH1

EN1045 FH 10

**Composition**

Mixture of fluoroborates, metaborates, potassium tetrafluoroborates, and boric acid.

**Physical characteristics**

Working temperature range:

550 - 850 °C

Presentation form:

Paste / Powder

Colour:

White

**Range of application:**

Flux for brazing with silver-based filler metals, with wide working temperature range.

It is available in both paste and powder form.

It can be used on steel, copper and copper alloys, nickel and nickel alloys base metals.

Suitable for torch and for induction brazing processes.

Product is used by brushing it on the base metals prior to heating.

Powder can also be mixed with water to form a paste.

Flux residues are corrosive and have to be removed after brazing by brushing or by dipping into cold water.

**Characteristics Make-up:**

Paste: Packages of 0,1 – 0,25 – 0,5 – 1 – 1,5 – 10 – 20 kg

Powder: Packages of 0,1 – 0,25 – 0,5 – 1 – 10 – 20 kg

Other packages are available upon request

The above data are subject to change without notice by Stella.

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