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Flux-Green-Filler-Stop

Using in Brazing Process

Introduction of Flux-Green-Filler-Stop (GFS)

As the name of this product type indicates, Flux-Green-Filler-Stop (GFS) “stops” molten brazing filler metal from flowing into areas where it unwanted, thus the surfaces remain clean and free from the presence of any filler metal.

Brazing filler metals do not like to bond with, or flow over, any dirt, grease, or oxides so the presence of any of such contaminants can prevent the filler metal from flowing over the surfaces of parts to be brazed where these contaminants are located.

Therefore, GFS compounds are very effective at preventing molten filler metal flowing into protected areas. The GFS compounds are mixed with a liquid carrier solution and can be applied onto metal surfaces by using a small brush or by spraying or dipping. Note: please stir GFS thoroughly before use unless you achieve a homogeneity in a whole package.

Usually GFS is applied as a thin, continuous line around critical areas on a metal’s surface where filler metal should not flow. Because filler metals do not like to bond with, or flow over, oxides on metal surfaces, the presence of an adherent line of GFS on the metal’s surface stops the filler metal flow – effectively telling the filler metal: “This far, but no further”.

Chemical Composition

Component	Concentration
Pigment	32–38 %
Lacquer Solids	n.a.
Water	62–68 %

Physical Properties

Form	Liquid
Colour	Green
Odour	No odour



Main Features of Flux-Green-Filler-Stop

- To prevent brazing filler metal from flowing over, bonding to or any protected surfaces
- To prevent the contamination of base or filler metal
- To prevent a sintering of stacked parts during furnace brazing
- To be used on any type of metal and in any type of brazing process
- To run as a masking agent when thermal spraying metallic coatings
- To make heat-resistant marks for identification purposes
- etc.

Flux filler stops are used to prevent cores (f.e. HEX) bonding to brazing jigs, trays, fixtures etc.



Physical Data

Melting point/-area	n.a.
Boiling point/-area (Solvent)	100 °C
Flash point	not flammable
Inflammation	n.a.
Ignition temperature	n.a.
Selfflammation	n.a.
Vapour pressure	> 1 mbar
Vapour density	< 1 mbar
Specific gravity (20 °C)	1.16 g/cm ³
Solubility in water (Binder)	100 % g/l
Solubility in water (Inert powder)	insoluble
Evaporation rate	slower than ether

Cautions

- GFS should not be used as an excuse for allowing the use of too much brazing filler metal.
- Once Flux-Green-Filler-Stop has been applied and the filler metal flow is stopped, there is no return. It is not possible to simply wipe the GFS from the surface and expect that surface to become brazeable once again. Residues from the “stop-off” still remain and the GFS will prevent wetting on that surface.

The only methods to effectively remove stop-off from surfaces are to thoroughly clean the surface ultrasonically, or to machine off the contaminated top surface layer.



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