













FLUX-COATED FILLER METALS

The flux-coated filler metals are composed of the preformed filler metals and coated flux. The products are similar to flux-cored filler metals in terms of improving brazing automation and efficiency as well as the quality stability. A variety of flux-coated filler metals with different functions can be selected by the customers.

C Copper
 B Brasses
 F Ferrous metal
 C Cemented carbide

| Code | Description | | | | | | Base Metal | Product Forms | Introduction |
|------------|----------------------|------------------|---------|---------|--------------|-----|------------|---|--|
| | Specification /wt. % | | | | | | | | |
| HUAGUANG | BCu92PAg | Cu | P | Ag | - | - | C |  | Flux-coated brazing rings are mainly used in the high frequency brazing of copper and brass. They have good fluidity and are widely applied in the industries of air-conditioning and refrigeration. |
| GB/T 6418 | - | rem. | 6.8~7.2 | 0.8~1.2 | - | - | B |  | |
| AWS A5.8 | - | Melting Range/°C | | | Joint Gap/mm | | |  | |
| ISO 17672 | - | 650~800 | | | 0.05~0.13 | | | | |
| HUAGUANG | BCu91PAg | Cu | P | Ag | - | - | C |  | Flux-coated brazing rings are mainly used in the high frequency welding of copper and brass. They have good fluidity and are widely applied in the industries of air-conditioning and refrigeration. |
| GB/T 10046 | BCu91PAg | rem. | 6.8~7.2 | 1.8~2.2 | - | - | B |  | |
| AWS A5.8 | BCuP-6 | Melting Range/°C | | | Joint Gap/mm | | |  | |
| ISO 17672 | CuP 280 | 643~788 | | | 0.05~0.13 | | | | |
| HUAGUANG | BAg21CuZnMnSn | Ag | Cu | Zn | Sn | Mn | B |  | Flux-coated brazing rods with high silver content are mainly used in the welding of brass and ferrous metal in the industries of air-conditioning and valves. |
| GB/T 10046 | - | 20~22 | 35~39 | rem. | 1.5~2.5 | 6~8 | F |  | |
| AWS A5.8 | - | Melting Range/°C | | | Joint Gap/mm | | |  | |
| ISO 17672 | - | 680~780 | | | 0.07~0.15 | | | | |
| HUAGUANG | BAg40CuZnSn | Ag | Cu | Zn | Sn | - | C |  | Flux-coated brazing rods with high silver content are mainly used in the welding of brass and ferrous metal in the industries of air-conditioning and valves. |
| GB/T 10046 | BAg40CuZnSn | 39~41 | 29~31 | 26~30 | 1.5~2.5 | - | F |  | |
| AWS A5.8 | BAg-28 | Melting Range/°C | | | Joint Gap/mm | | |  | |
| ISO 17672 | Ag 140 | 650~710 | | | 0.07~0.20 | | | | |

