

ROOFINOX®

Like no other.

Roofinox FLM

The stainless steel flux



Advantages at a glance

- Soldering fluid for stainless steel, tinned stainless steel and copper
- For all Roofinox surfaces
- Allows easy soldering
- Quick depassivation
- Dissolve light discoloration from soldering

Technical information

- For Roofinox fluxes based on phosphoric acid are suitable. Not suitable are fluxes based on hydrochloric acid or dilute hydrochloric acid or containing chloride ions.
- Roofinox FLM guarantees sufficient removal of the thin passive layer and prevents its renewed formation during soldering. They provide optimal wetting and cleanliness of the soldering area.
- After soldering, flux residues must be carefully removed with clean water.
- For Roofinox Spectra: Pigment removal necessary before use.
- Content of one bottle Roofinox FLM: 1000 ml

Application Roofinox FLM

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Required items for durable and clean soldered seams:

- Soldering iron with soldering bit
- Solder (30 %, 40 %, 50 % solder possible)
- Soldering stone / ammoniac stone
(pure ammoniac, no tinned ammoniac stone)
- Flux - Roofinox FLM
- Flux brush
- Cleaning tissue
- Fresh water

Apply Roofinox FLM to the solder joint

Apply flux with a brush along the joint. This dissolves the passive layer and enables the bonding of solder and metal surface. Best liability will be achieved when both the bottom and top panels are coated with FLM. The mechanical connection with rivets is to ensure with stainless steel. The solder has just a sealing function. You can find detail information in our Roofinox soldering brochure.



Post-cleaning

After soldering the flux residues have to be cleaned. For cleaning procedure wet a cleaning tissue or cloth. Clean the joint thoroughly, remove all residues of flux. Should you have spilled flux, rinse with plenty of fresh water to prevent corrosion or discoloration.



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