**Specification for** 

# Phosphoric acid based flux for soft soldered joints in stainless steel



 $ICS \ 25.160.50$ 

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British Ironfounders' Association	Institution of Production Engineers		
British Mechanical Engineering	Institution of Structural Engineers		
Confederation	Lloyd's Register of Shipping		
British Steel Industry*	Ministry of Defence		
British Steel Industry (Wire Section)	National Association of Drop Forgers		
The Concrete Society	and Stampers		
Council of Ironfoundry Associations	Oil Companies Materials Association		
Department of Employment, H.M. Chief	Process Plant Association		
Inspector of Factories	Royal Institute of British Architects		
Department of Industry N.P.L	Shipbuilders' and Repairers' National		
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Greater London Council	Steel Castings Research and		
Institute of British Foundrymen	Trade Association		
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The organization marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this standard:

British Gas Corporation British Welded Steel Tube Manufacturers' Association Copper Development Association Institute of Plumbing National Water Council Water Companies Association

This British Standard having been approved by the Iron and Steel Industry Standards Committee, was published under the authority of the Executive Board on 30 September 1975

Amendments issued since publication

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The following BSI references relate to the work on this standard: Committee reference ISE/66 and ISE/66/1 Draft for comment 71/40639

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### Foreword

This British Standard, authorized by the Iron and Steel Industry Standards Committee, has been prepared at the request of the stainless steel industry. Because of the inadvisability in some cases of using acid chloride fluxes in making capillary joints in stainless steel tube, a decision was taken to prepare this standard for phosphoric acid based flux particularly for the application of preparing soft soldered capillary joints in stainless steel tube in accordance with BS 4127 "Light gauge stainless steel tubes", Part 2 "Metric units", with solder in accordance with BS EN 29453 "Soft solder alloys - Chemical composition and forms" and fittings of copper or copper alloy in accordance with the relevant part of BS EN 1254 "Copper and copper alloys - plumbing fittings" or of stainless steel. It is intended to ensure that purchasers of phosphoric acid based flux for use in this application may be certain that such fluxes and their residues are safe, i.e. not corrosive in normal use, towards the tube, fittings, or solder in the capillary joints after the joint has been made. The type of flux covered by this standard may, however, be used for other applications where soldered joints in stainless steel are involved.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

#### Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 4, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.