

Unisil[®] Flux Agent

- by Unipak

Unisil[®] Flux Agent for hard soldering, of copper pipes in both cold and hot water installations.

is a soldering flux agent for hard soldering of copper pipes in connections with brass and brass fittings. Used in both cold and hot water as well as oli and gas installations.

Soldering is a method of joining metal parts, where two or more items are joined with a molten material - Unitin or Unisilver. The soldering process takes place by heating the parts to be joined to a temperature lower than their melting temperature. Thereby, the solder metals melts and flows into the solder pieces. During solidification, a metallic bond appears between the solder and the solder items, which creates the solder joints itself.

Soldering is divided into soft- and hard soldering. Soft soldering with Unitin is carried out with Unitin at 450 °C, hard soldering with Unisilver at 450 °C - 850 °C.

A prerequisite for a correct solder joint to be created is that the molten solder metal is able to flow onto the solder items to be joined. If the surface is contaminated with rase, dirt or oxides, direct contact between the solder items and the solder metal is prevented.

The solder blanks are cleaned with Univlies as cleaning pieces are rubbed/pushed hard against the area that will later be soldered. Univlies are used to prepare the soldering area for both hard- and soft soldering.

Flux agent is applied to the cleaned solder areas - Uniplus for soft soldering and Unisil for hard soldering. The flux agent ensures that



the oxidation layer on the metal is removed so that contact can occur directly between the solder pieces and the solder.

With both hard- and soft soldering, the solder items are fed/sucked into the transition between the solder items (typical pipe end and solder seelve) by means of capillary force. Therefore, the solders to be assembled must be carefully matched to each other. The cleaned and lubricated with flux agent are now assembled and heated to such a high temperature that the solder easily and by itself flows into the joint between the solder blanks when the tin is brought in contact with the solder blanks where soldering is desired - typically in the gap between the pipe and the solder sleeve.

Unitin has a melting point of 230 °C, so solder areas and the solder pieces must be heated to at least this temperature for soft soldering to work. Our Unisilver has a melting point of 640 °C, so here the soldering area and the soldering items must be heated to at least this temperature for the brazing to work.

INTRUCTIONS FOR USE:

1. Clean all surfaces to be soldered using a Univlies Cleaning Pad.
2. Apply flux agent from the supplied can.
3. Heat up the soldering point immediately after applying flux agent. The soldering point must be heated to the appropriate temperature for the material.
4. Add Unisilver solder into the solder gap.
5. Allow the soldering point to cool down and wipe off if necessary. Wipe off excess flux agent with a damp cloth.

Remember to flush the system through before commissioning.

Packaging	Item no.	EAN no.	VVS no.	RSK no.	NRF no.	LVI no.
100 g can	4545210	5708923453044	043006210	2018056	9507925	7075313

Additional product information, safety data sheets, demo videos, instructions for use, etc. can be found at: www.unipak.dk

As we constantly develop our products, we reserve the right to be reliable.

We cannot assume responsibility for the results obtained by others over whose methods we have no control.

It is the user's responsibility to determine suitability for the user's purpose of any application methods mentioned herein.