

Specification for

Phosphoric acid based flux for soft soldered joints in stainless steel

ICS 25.160.50

NO COPYING WITHOUT BSI PERMISSION EXCEPT AS PERMITTED BY COPYRIGHT LAW



Document Sharing Hub

Co-operating organizations

The Iron and Steel Industry Standards Committee, under whose supervision this British Standard was prepared, consists of representatives from the following Government departments and scientific and industrial organizations:

British Cast Iron Research Association	Institution of Mechanical Engineers (Automobile Division)
British Constructional Steelwork Association	Institution of Production Engineers
British Ironfounders' Association	Institution of Structural Engineers
British Mechanical Engineering Confederation	Lloyd's Register of Shipping
British Steel Industry*	Ministry of Defence
British Steel Industry (Wire Section)	National Association of Drop Forgers and Stampers
The Concrete Society	Oil Companies Materials Association
Council of Ironfoundry Associations	Process Plant Association
Department of Employment, H.M. Chief Inspector of Factories	Royal Institute of British Architects
Department of Industry N.P.L.	Shipbuilders' and Repairers' National Association
Department of Trade (Marine Division)	Society of Motor Manufacturers and Traders Ltd.
Engineering Equipment Users' Association	Steel Castings Research and Trade Association
Federation of Civil Engineering Contractors	Tin Research Institute
Greater London Council	
Institute of British Foundrymen	
Institute of Marine Engineers	

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

© BSI-05-1999

The following BSI references relate to the work on this standard:

Committee reference ISE/66
and ISE/66/1
Draft for comment 71/40639

ISBN 0 580 08755 7

Amendments issued since publication

Amd. No.	Date	Comments
10208	January 1999	Indicated by a sideline in the margin

Contents

	Page
Co-operating organizations	Inside front cover
Foreword	ii
1 Scope	1
2 References	1
3 Information to be supplied by the purchaser	1
4 Composition	1
5 Condition	1
6 Sampling	1
7 Solderability test	1
8 Retests	1
9 Inspection	1
10 Facilities for testing	1
11 Packaging	1
12 Marking	1
13 Manufacturer's certificate	1
Appendix A Method for the determination of halogen content	2
Appendix B Solderability test	2
Figure 1 — Jig for holding stainless steel test pieces	3
Figure 2 — Area of solder spread	4
Publications referred to	Inside back cover