Z.A.E. la Neuvillette 60240 FLEURY (France)
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TECHNICAL DATA SHEET

BONDING OF LIGHT ALLOYS WITH HIGH MAGNESIUM OR MANGANESE CONTENT

FLUXAL 1240

❶➢ PRODUCT DESCRIPTION.

The FLUXAL 1240 is a powdery, mineral composition designed for brazing aluminium with silicon clad aluminium.

❷➢ CHARACTERISTICS - PHYSICO-CHEMICAL PROPERTIES, COMPOUND ELEMENTS.

Hygroscopic alkaline-muddy salts

❸➢ APPLICATION FIELD.

Internal and external brazing of light alloy parts for the automotive and aircraft industries by soaking them in FLUXAL 1240.

❹➢ DIRECTIONS FOR USE.

The parts are sometimes pre-heated then dipped into the molten salt bath at a temperature range between 580 and 610°C depending upon the silicon content and the alloys to be joined..

They are then removed from the bath and allowed to drain. The adhering action occurs during the cooling process.

After brazing, the parts must be washed with a hot nitric acid solution (conc. 5 %) in order to remove any residual salts.

The bath is refilled by slowly adding Fluxal 1240. Before use aluminium strips should be dipped into the bath to dehydrate and de-gas the bath, the frequency of which is dependant upon the quantity of salt bath fluxal 1240 that has been added.

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I.R : 1

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Control of the bath is performed by regular analysis of the following =

- FLUORIDES
- CHLORIDES
- PH LEVEL

Store FLUXAL 1240 carefully sealed in its original packaging (highly hygroscopic product)

❺➢ USING CARE AND RECOMMENDATIONS

For all other information please see the Material Safety Data Sheet also available on our web site (www.stts-flux.com) or contact us directly.

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