



stts
Brazing solutions

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TECHNICAL DATA SHEET

FLUXAL 1216

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Torch brazing of light alloys

. PRODUCT DESCRIPTION

Fluxal 1216 is a mineral hygroscopic powder flux intended for torch brazing of aluminium with aluminium silicon clad or AlSi 12 in form of wire.

. PRODUCT CHARACTERISTICS

Composition : from alkaline-muddy chlorides and fluorides

. PRODUCT APPLICATIONS

Typically it is used in the automotive industry, for cooking utensils etc.

. DIRECTIONS FOR USE

Brazing temperature is typically between 550°C and 650°C.

The flux is designed to be used diluted in a 2:1 ratio, flux : water. This mixture should be stirred vigorously. The reaction on mixing with water is exothermic. A thin and stable suspension is obtained, which must be continuously stirred.

The flux can be brushed on as a paste or applied to the components as a powder.

Heating method used is torch brazing of aluminium alloys with Aluminium-silicon (7-12%) alloy.

Fluxal 1216 leaves corrosive residues that require post-braze washing and must not be left on the components. For best results spray or dip hot components in cold water, hot water rinse, wash with hot (50°C) 5-10% nitric acid solution followed by final hot, then cold, washes.

. USING CARE AND RECOMMENDATIONS

Use with fume extraction and protective clothing. Refer to health and safety datasheets before use.

