



FLUXAL 1261

Date de révision :
04/11/2014 JPF
IR : 3

AIR FURNACE BRAZING AND BONDING OF LIGHT ALLOYS

. **PRODUCT DESCRIPTION**

Hygroscopic mineral flux powder with strong pickling power for the brazing of aluminium and silicon clad aluminium with a high content of magnesium or manganese through an air furnace.

. **CHARACTERISTICS - PHYSICO-CHEMICAL PROPERTIES, COMPOUND ELEMENTS**

Composition : alkaline-muddy chlorides and fluorides.

. **APPLICATION FIELD**

USERS

Automotive and aircraft OEM for the manufacture of silicon clad aluminium heat exchangers through an air furnace.

APPLICATION FIELD

Furnace brazing : Aluminium and silicon clad aluminium (7 to 12%).
Brazing temperature : from 530 to 640° C.

. **DIRECTIONS FOR USE, USING ADVICE, COMMON USING CONCENTRATION**

Preparation of the flux : Mix 2/3 flux with 1/3 water and stir vigorously. The reaction

For large quantities, the preparation tank must be thermally controlled. A thin and stable suspension is obtained, which must be stirred continuously.

Parameters to be controlled :

- Temperature during preparation
- Concentration, density, viscosity, stability (sedimentation time)



stts
Brazing solutions

STTS
Z.A.E. LA NEUVILLETTE
60240 FLEURY - FRANCE
☎ +33 3 44 49 02 19
✉ +33 3 44 49 11 40
✉ stts@stts-flux.com

TECHNICAL DATA SHEET

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PROCESS : - Fluxing by dipping

Fluxing by spraying

When air furnace brazing, the quantities of flux on the parts must be well defined and the brazing temperature adjusted between 600 and 615° C depending on the parts to be brazed

MATERIAL : the flux is a hygroscopic, acidic and corrosive product. Because of this, the tank and mixers must be made of stainless steel, and the handling materials (tubes, fluxing cabin etc.) must be made of suitable plastics.

FLUX RESIDUE REMOVAL: First spray or dip hot parts in cold water. Then rinse with hot water, and wash with hot nitric acid solution (Temperature: 50° C ; Acid concentration : 5 to 10 %). Finally rinse the parts in hot and then cold running water.

. USING CARE AND RECOMMENDATIONS

For all other information please see the material safety data sheet also available on demand

ISO 9001
ISO 14001
BUREAU VERITAS
Certification

