



stts
Brazing solutions

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TECHNICAL DATA SHEET

NITRAL 1251

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IR : 2

Brazing of light alloys by the «C.A.B.» process

. PRODUCT DESCRIPTION

A mixture of potassium fluoroaluminates supplied as a white powder.

. CHARACTERISTICS - PHYSICO-CHEMICAL PROPERTIES, COMPOUND ELEMENTS

This F – LH2 flux is made of a mixture of fluororaluminates, which allows the brazing of parts at high temperatures.

- Melting range "on set" 563 – 572° C
- Density 0,6 +/-0.01
- PH 6 – 7 10% solution in distilled water
- Water Content < 3 %

. APPLICATION FIELD

NITRAL 1251 is intended for the brazing of aluminium parts or heat exchangers clad with Aluminium/Silicone by the C.A.B. process (Controlled Atmosphere Brazing).

. DIRECTIONS FOR USE

After degreasing and pickling, the parts to be brazed are fluxed by dipping or spraying. They are then drained and dried at about 300° C (575° F). After preheating the parts, they are brazed in a furnace at 600 – 605° C (1112° F – 1121° F).

This is followed by a cooling stage.

The brazed parts are perfectly clean and without any corrosive residues. No further cleaning of the parts is required thus eliminating any pollution issues, and therefore reducing costs.

Adjustments and quantities of flux to be applied are determined by our technical department during the set-up and preparation of the fluxing solution.

To keep a stable solution, the flux bath must be continuously stirred.

. USING CARE AND RECOMMENDATIONS

Without particular risk

Refer to health and safety datasheet before use also available on demand

ISO 9001
ISO 14001
BUREAU VERITAS
Certification

