FLUX ALUNOX NCs

Non-Corrosive Aluminium Brazing Flux

TECHNICAL DATA SHEET 415

Specifications:

Base	Active Temperature Range (˚C)	NF EN 1045
Cs-Al-F Complex Mixture	400 - 450	FL 20

Characteristics:

ALUNOX NCs is non-corrosive flux to be used for soft brazing Aluminium and low alloyed Aluminium alloys (except aluminium with magnesium contents) with Stainless or Copper. The flux is suitable for all flames used for brazing, Induction brazing and Resistance brazing procedures. It does not fume. **This Product is RoHS Compliance.**

Applications:

ALUNOX NCs is recommending to be used for brazing Aluminium Alloys Typical applications are brazing radiators, heating elements, sandwich bottom pots and deep fat fryers.
To be use with ours **ZINAL 4** Alloy

Physical Properties:

Colour	Solidus Temperature (˚C)	Bulk Density g/cm^3	Corrosive
White Powder	400	3.80	non

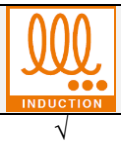
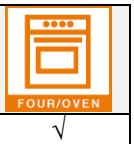
Direction of Use:

ALUNOX NCs flux powder should be mixed with water (Recommended ratio of flux to water (distilled/ demineralised) is 1:1 or 1:1.5. Stir the mixture thoroughly. Apply the mixture across the joint surface before assembled by brush. Further flux should then be applied externally on the either side of joint.
Hot Rodding is where, a warm brazing rod is dipped into flux powder and flux adhering to the rod is transferred to the joint area. This is an effective fluxing method but difficult to achieve good penetration of capillary joints. It can be used to supplement a pre-fluxed area during heating. For Flame brazing, the flux is only conditionally suitable (due to relatively short time until the flux will be saturated with oxides).
It is good practice to mechanically clean and degrease the joint surface before applying flux. Heat slowly and evenly to the brazing temperature, without local overheating. Use flux as a temperature guide, i.e. it will become clear or opaque as brazing temperature is reached. If blackening of the surface occurs this is often sign of insufficient flux, overheating or flux exhaustion.

Flux Residue Removal:

The Flux being a non-corrosive in nature there is no need to remove the flux residue after brazing from the component.

Standard Packing and Storage:

Standard Packing (gm)							
60	200	500	1000	OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
X	√	√	√	√	√	√	√

Customised packing other than above standard dimensions is solicited case to case basis.
Flux to be stored in the temperature range +5 to 30˚C. Avoid rapid changes in temperature.

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

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