

Non-Corrosive Pastes Al-Flux 028 Range

Description: The Al-Flux 028 flux paste range contains non-corrosive controlled atmosphere brazing (CAB) flux, Al-Flux 2805 with an organic carrier or water carrier system. Some of these products are cesium complex enhanced.

Physical Properties

Appearance: pastes
Melting Range: See table below

Packaging

As per your request

Non-Corrosive-Flux-Pastes are classified as an irritant according to current regulations.

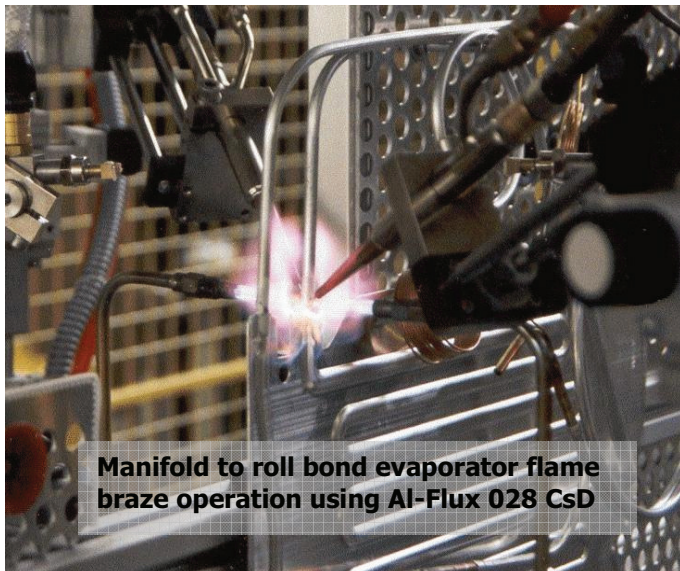
Classification

Observe usual chemical handling precautions

Please see Material Safety Data Sheet (MSDS) for additional, product specific information.

Product Range:

| Product Name | Cesium Enhanced | Melting Range | Comment |
|---------------------|-----------------|----------------|--|
| Al-FLUX 028/50 90 T | No | 550 °C -600 °C | High concentration fluxing of braze joints |
| Al-FLUX 028/55 | No | 550 °C -600 °C | High concentration fluxing of braze joints |
| Al-FLUX 028/55 Cs2 | Yes | 430 °C -600 °C | Used for materials with moderate magnesium or copper content, low cost material for AlZnSi-Special wire |
| Al-FLUX 028/55 Cs3 | Yes | 430 °C -600 °C | Used for the new AlZnSi-Special wire |
| Al-FLUX 028 Cs | Yes | 420 °C -600 °C | Used for materials with high magnesium or copper content e.g. 6061, 6063 |
| Al-FLUX 028 CsD | Yes | 420 °C -600 °C | Used for materials with high magnesium or copper content e.g. 6061, 6063. Use for low temperature flame braze and repair of condensers in conjunction with ZnAl2, ZnAl4, AlZn15 and Zn-mod filler wire |
| Al-FLUX 028 CsWD | Yes | 420 °C -600 °C | Same as above, Water carrier used instead of organic carrier system |



Non-Corrosive Pastes

Al-Flux 028 Range

Al-FLUX 028 flux pastes contain Al-Flux 2805 non-corrosive flux as the active component. Cesium complex is added to some variants. The cesium is very effective at managing high magnesium and high copper content in aluminium alloys used.

The cesium complex component is active at the same temperature range as the magnesium and copper in modern aluminium alloys. It prevents magnesium and copper oxides forming on the component surfaces.

The post braze flux residues are non-corrosive, they do not need to be removed or chemically neutralized.

These pastes are widely used in flame, induction and controlled atmosphere braze furnace operations. Typically applied to braze critical joints by dispense, brush or, in some cases, by spray application. Used in joint situations where filler metal is present in the form of a clad layer or filler metal shim and wire pre-forms are positioned in the joint area.

Multi flow condenser connector block (typically AA 6063) to header pipe furnace brazing is improved by applying Al-FLUX 028/55 Cs2 to the joint area.

Pipe to connector brazing is made easy by using these pastes. Al-FLUX 028 CsD is especially useful when flame brazing AA 6061 and AA 6063 (and equivalent alloys). Also used for low temperature (420 °C -500 °C) leak repair of condensers and evaporators in conjunction with AlZn2, AlZn15 and Zn-mod filler wire.

Products are supplied as ready for use, requiring stirring only, no component mixing is required.

Al-Flux 028 Pastes:

- CAB flux (Al-Flux 2805)
- Organic carrier system
- Cesium complex can be added

Process:

Application:

- Dispense
- Brush
- Spray

Brazing:

- Controlled Atmosphere Brazing (CAB)
- Induction
- Flame

Benefits of Al-Flux 028 Pastes:

- Cost competitive product
- Non corrosive residue, no need to remove or neutralize
- Improved process
- Excellent braze fillet formation
- Cesium enhanced pastes significantly improve braze ability of Mg and Cu bearing alloys

Conclusion:

Al-Flux 028 flux pastes provide practical solutions for the application of high concentration flux to braze critical joints.

FLUX GmbH is the leader in fluxing technologies and is continuously developing customer specific solutions to achieve maximum cost benefit in the processing sequence of heat exchange products. Issued 04/2011

