

Non-Corrosive Pastes With Filler-Metals Al-Flux 9028 Range

Description: The Al-Flux 9028 flux paste range contain non-corrosive controlled atmosphere brazing (CAB) flux, Al-Flux 2805, aluminium filler metal, AlSi7, with an inorganic carrier system.

Physical Properties

Appearance:	Grey paste
Boiling Range	184 -189°C
Melting Range (Flux):	550 -560°C
Melting Range (AlSi7):	577 -595°C
Odor:	Neutral

Specification (CAB Flux)

K	29-34 %
Al	14-17 %
F	47-52 %
Fe ₂ O ₃	max 0.025 %
SO ₄	max 0.010 %
Si O ₂	max 0.200 %
Cl	max 0.020 %
H ₂ O	approx 3.000 %

Classification

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

Observe usual chemical handling precautions

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

Packaging

As per your request

The pastes listed below are available in various viscosities and flux to filler metal ratios to suit specific customer requirements.

Product Name	Comment
Al-FLUX 9028E	Standard, for general use
Al-FLUX 9028 HC II	Cesium enhanced, well suited for applications where high magnesium materials are used.
Al-FLUX 9028 E 45 DI	High metal content, suited to robotic dispensing applications.

Non-Corrosive Pastes With Filler-Metals

Al-Flux 9028 Range

Al-FLUX 9028 flux pastes contain Al-Flux 2805 as the active component. AlSi7 metal is added as a filler metal.

These pastes are widely used where additional filler metal is required and can replace most braze operations where filler metal rings and flux pastes are used. The advantage is that a single product is used. No mixing is required. No filler metal pre-forms need be manufactured and stocked. Flux and filler metal are applied in a single, controllable, operation and the flux to filler metal ratio is controlled. This reduces unwanted post-braze crystals as a result of over fluxing.

Uses include problematic braze joint areas on furnace brazed aluminium heat exchangers, for example, large gaps at tube to header joints caused by poor part stamping. Leaks can be repaired by applying Al-Flux 9028E to the leak area and re-brazing the defective unit.

Multi flow condenser connector block to header pipe brazing is improved by the use of Al-Flux 9028E. Al-Flux 9028 HC II can be used if the connector material contains significant amounts of magnesium.

Non-clad parts can be joined using these pastes.

Al-Flux 9028E paste is used extensively in the cookware industry to join aluminium bases to stainless steel pots.

Al-Flux 9028:

- CAB flux (Al-Flux 2805)
- AlSi10 Filler metal
- Inorganic carrier system
- Cesium complex can be added

Process:

Application:

- Spray
- Dispense
- Dip
- Brush

Brazing:

- Controlled Atmosphere Brazing (CAB)
- Induction
- Indirect flame

Benefits Of Al-Flux 9028:

- Cost competitive product
- Improved process
- Reduced inventory
- Balanced flux to filler metal ratio
- Excellent braze fillet formation

Conclusion:

Al-Flux 9028 flux pastes provide practical solutions for the application of filler metal in braze 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.

