# 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 |

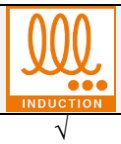
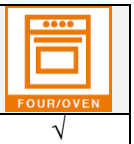
### Direction of Use:

**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.**



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