

### TECHNICAL DATA SHEET 412

#### Specifications:

Base	Active Temperature Range (°C)	NF EN 1045	Approval
Alkaline Chlorides + Complex Fluorides	>550	FL 10	-

#### Characteristics:

**FLUX ODAL** is corrosive flux to be used for brazing Aluminium and low alloyed Aluminium alloy. The flux is not recommended for brazing Mg-bearing alloys. It gives very good alloy wettability and good deoxidising action. 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:

**FLUX ODAL** is recommending to be used for brazing Aluminium Alloys Typical applications are brazing radiators, heating elements, sandwich bottom pots and deep fat fryers.

#### Physical Properties:

Colour	Solidus Temperature (°C)	Bulk Density g/cm <sup>3</sup>	Corrosive
White Powder	400	-	Yes

#### Direction of Use:

**FLUX ODAL** 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 corrosive in nature there is needed to remove the flux residue after brazing from the component. Immersion of the part in the boiling water. A chloride flux is highly soluble in water and the boiling water removes most of it.

#### Standard Packing and Storage:

Standard Packing (gm)							
150	200	400	1000	OXV/ACETYLENE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
X	✓	X	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.