

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Al-Si	590	Al 112	BAISi-4	L-Al Si 12	B-Al88Si-575-585	-

Characteristics:

HARASIL NC 12 TBW is a Seamless tubular wire of AlSi12 with non-corrosive flux. This wire is adaptable for brazing of Aluminium and Low Aluminium alloys with solidus temperature $\geq 630^{\circ}\text{C}$. Alloy used with torch, Induction and furnace brazing heat source. Fluid filler alloy with cored with non-corrosive flux (Flux ratio is $18 \pm 2\%$) gives very good capillary action, ductility and penetration with excellent corrosion resistance. Flux being non-corrosive nature, no need of post brazing cleaning. Gives very strong joints. No separate flux to apply need flux handling systems or corrosive flux to apply. Product does not fume.

Applications:





HARASIL NC 12 TBW can be used for braze piping connections of aluminium and aluminium alloys used for Heat exchangers, Air conditioners, Heat diffuser Discs, Condensers and Automotive refrigeration systems. Brazing of Sandwich bottoms utensils, Heating elements and Radiators. Also used for joining Copper to Aluminium alloy.

Chemical Compositions of alloy (%):									
Al	Si	Zn	Fe	Mn	Mg	Cd	Pb	Cu	Max. impurities other
Rem.	11.0-13.0%	<0.20	<0.80	<0.15	<0.10	<0.010	<0.025	<0.3	<0.15
Typical Physical Properties:									
Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)		Electrical Resistivity (Micro-ohm-cm)	
Silver Grey	575	585	2.65	20	140	-		-	

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size (mm)	Type			 OXYACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Cut Length	Coil/ Spool	Preforms				
1.20 to 3.00	✓	✓	✓	✓	✓	✓	✓

Customised sizes and other type other than above standard dimensions are solicited case to case basis

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