HARASIL NC12 FCW

Flux Cored Wire Aluminium Alloys

TECHNICAL DATA SHEET 409C

Specifications:

Alloy	Working Temperature (˚C)	NF EN ISO 17672	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Al-Si	585	Al 112	BAlSi-4			-

Characteristics:

HARASIL NC 12 FCW Flux Cored wire of AlSi12 with non-corrosive flux. This wire is adaptable for brazing of Aluminium and Low Aluminium alloys. Alloy used with torch, Induction and furnace brazing heat source. Fluid filler alloy with cored with non-corrosive flux 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 FCW 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. Heating elements and Radiators.

Typical Chemical Compositions of alloy (%):

Al	Si	Zn	Fe	Mn	Mg	Cd	Pb	Max. impurities
Rem.	11-13	<0.20	<0.80	<0.15	<0.10	<0.010	<0.025	<0.15

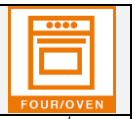
Typical Physical Properties:

Colour	Solidus (˚C)	Liquidus (˚C)	Density g/cm^3	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity. (Micro-ohm-cm)
White metal	575	585	2.66	15-30	125-150	46	-

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						
	Cut Length	Coil/ Spool	Preforms	OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
1.50 - 3.00	√	√	√	√	√	√	√

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