

## TECHNICAL DATA SHEET 408B

### Specifications:

Alloy	Working Temperature (°C)	DIN 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:

**TBM 12NCs 20** Composite rod consisting of a homogeneous mixture of aluminium alloy and a non-corrosive flux for high-strength brazing of sheet, forged or cast parts in aluminium alloys. non-corrosive flux. Alloy to Flux ratio is maintain at 86:14. 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. High Fluid filler alloy with non-corrosive flux gives very good capillary action, No extra flux required. The higher %Cs containing flux is more aggressive than conventional non-corrosive flux. The ductility and penetration of the alloy with excellent corrosion resistance. No post-braze cleaning required being non-corrosive flux. Excellent electrical conductivity Good colour match on aluminium. No separate flux to apply, need flux handling systems or corrosive flux to apply. Product does not fume.

### Applications:

**TBM 12 NCs 20** Aluminium parts repair, Aluminium connectors, heat exchanger, air conditioning and refrigeration systems, connection of pipe Aluminium, radiators, automotive etc. **Strongly recommended for Magnesium bearing aluminium-alloy (Mg<1.20%)**. Also used for joining Copper to Aluminium alloy.

### Typical Chemical Compositions (%):

Al	Si	Zn	Fe	Mn	Mg	Cd	Pb	Cu	Max. impurities
Rem.	11.0-13.0	<0.20	<0.80	<0.15	<0.10	<0.01	<0.025	<0.3	<0.15





### Typical Physical Properties:

Colour	Solidus (°C)	Liquidus (°C)	Density g/cm <sup>3</sup>	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Metallic aluminium	575	585	2.65	-	-	-	-

### 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 and Types:

Size (mm)	Type			 OXY/ACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Cut Length	Coil	Preforms				
1.20 - 3.00	✓	✓	✓	✓	✓	✓	✓

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

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