

TECHNICAL DATA SHEET 408

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:

TBM 12NCs 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. Good Colour Match. Low bonding temperature. Excellent electrical conductivity. This wire is adaptable for brazing of Aluminium and Low Aluminium alloys. Alloy used with torch, Induction and furnace brazing heat source. High Fluid filler alloy with non-corrosive flux, which gives very good capillary action and alloy flow, No extra flux required. The ductility and penetration of the alloy with excellent corrosion resistance. No post-braze cleaning required being non-corrosive flux. No separate flux to apply need flux handling systems or corrosive flux to apply. Product does not fume.

Applications:

TBM 12 NCs Aluminium parts repair, Aluminium connectors, heat exchanger, air conditioning and refrigeration systems, connection of pipe Aluminium, radiators, automotive etc. Also used for joining Copper to Aluminium alloy. **Not recommended for aluminium-magnesium alloy (Mg>0.60).**

Chemical Compositions of alloy (%):

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 ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity	Electrical Resistivity (Micro-ohm-cm)
Grey	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, Types and Heat Source Recommendations:

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

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

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