



T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

TECHNICAL SPECIFICATION SHEET

ISO 9002
Cert. No. 31598

ALBRAZE E.C. ALUMINUM BRAZING FLUX

STATEMENT OF LIABILITY- DISCLAIMER

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DESCRIPTION/DIRECTIONS:

A brazing flux in powder form designed for torch brazing aluminum. It is typically used to braze common aluminum base materials such as 1100, 3003, and 6061. It has a working temperature range of 915 to 1115 degrees F. It is recommended for use with aluminum brazing filler metals 4047 (718) and 4145. Flux can be sprinkled dry on the part or can be mixed with water or methyl, ethyl or isopropyl alcohol to form a paste.

Physical Properties:

Working Temperature range	915-1115°F
Appearance	White Powder
Specific Gravity	2.15
Self Life	1 year in unopened container, (store in protective packaging due to the hygroscopic property of the flux.)

FLUX RESIDUE:

Flux residue should be removed after brazing. The suggested procedure is to immerse part in boiling water. Flux residue is soluble in water and this process should remove it. Flux can be chemically removed by dipping parts in a 50/50 by volume of nitric acid and water. Care must be taken when using acid solutions. After the acid dip parts should be thoroughly washed in water.

SPECIFICATIONS:

AWS A5.31 FB1A, AMS 3412.

AVAILABLE FORMS:

1/2 Lb. Jars. Other sizes are available upon request. Also available as part of a brazing kit containing a 3/4 oz. coil of 1070 aluminum brazing wire and a 1/3 oz. of flux.

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

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