



## CS612

### Aluminum Brazing Powder Flux

#### Features

- Used in flame brazing of aluminum for production and repair
- Ease of application using dispensing equipment
- Consistent flux deposition
- No concentration monitoring required
- Creates excellent post braze cosmetics
- Significantly reduced post braze flux residues

#### Applications

- All-purpose flux for torch brazing with aluminum alloys. It is especially effective with common aluminum base materials such as 1100, 3003, and 6061. The recommended filler metals are 4047 (718) and 4145.
- Manufacturing - Architectural and Structural Metals, Mining, Agricultural, Motor Vehicles, Aerospace, Shipbuilding
- Construction - Residential, Commercial, Bridges, Dams, Utilities
- Or any other industry where welders may work

#### Technical Specifications

**Physical Properties:**

- Appearance: White paste
- Odor: Weak
- Boiling Range: 446°F (230°C)
- Melting Range: 1040 -1166°F (560-630°C)
- Flash Point: > 273.2°F (134°C)
- Ignition Temperature: 590°F (310°C)
- PH 68°F (20°C): 6-7
- Vapor Pressure 68°F (20°C): 0.01 hPa

**Specification:**

- Na 11-12.5%
- K 20-21.5%
- Li 3.5-4.5%
- Al ~ 1%
- Zn 3.5-4.5%
- Cl 51-52%
- F 6.5-8%

**Size:** 8 oz**Packaging:** Individually packaged, 12/Case**Country of origin:** Made in USA

#### Usage Instructions

- Mix the chloride based flux with a liquid that will make a paste
- Apply this to the base or filler alloy before the flame braze process takes place
- Afterward, rinse the area with warm water to remove the residue to leave a very aesthetic braze joint

*Note: Aluminum to aluminum; not recommended for brazing aluminum directly to non-aluminum alloys.*