



## Technical Bulletin

Issue 2 - 20/08/2018

### Aluflux

#### DESCRIPTION

Aluflux is an organic, reactive flux designed for the soft soldering of Aluminium. Aluminium has a thin, coherent oxide film on its surface, which forms very rapidly on exposure to air. This oxide film is so tough and chemically resistant that conventional fluxes will not remove it.

#### FEATURES AND BENEFITS

- Effective fluxing action – allowing aluminium to be soldered in a single operation, without the need for abrading the surface prior to soldering.
- Non-corrosive residues – Aluflux is not corrosive to aluminium at room temperature and for many applications, the small amount of post-soldering residue need not be removed. If necessary, however, the flux residue can be easily washed off with warm water.

#### APPLICATION

Aluflux can solder aluminium in a single operation by any of the conventional soldering methods e.g. blowtorch, soldering iron or hotplate. The flux effectively removes the oxide film and allows the solder to tin the base metal before the oxide film reforms. When flame soldering, a compressed air gas torch should be used and the flame directed close to the joint but not directly onto the flux. To avoid overheating, it is preferable for the flame to be directed to the underside of the substrate. It is essential that Aluflux reaches a soldering temperature of 300°C – a colour change indicates that the correct temperature has been reached.

#### AVAILABILITY

150g containers.

#### PHYSICAL/CHEMICAL PROPERTIES

|              |                                   |
|--------------|-----------------------------------|
| Appearance:  | Dark Yellow Suspended Liquid      |
| pH:          | 12 @ 5% w/w conc.                 |
| Odour:       | Odour: Faint, aromatic            |
| Flash Point: | N/A                               |
| Density:     | 1.2 gcm-3 @ 20°C                  |
| Solubility:  | Easily soluble in cold, hot water |

#### HEALTH AND SAFETY

Observe standard precautions for handling and use of corrosive liquids. Eye and skin protection must be provided. Avoid breathing fumes evolved during soldering. Adequate fume extraction should always be provided. For detailed information refer to the relevant Health and Safety Data Sheet (MSDS) available on request.

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