EutecTor Flux 190

For Aluminium and Aluminium Alloys

Description:
E+C flux in powder for use with filler alloys E+C 190.
Its power as a deoxidising agent makes in-position joining much easier, as well as repairs presenting difficult access.

Technical data:
500 - 700°C
white

Applications:
Base metals:
Aluminium and alloys (max. 1% Mg / 1% Si); dissimilar joining aluminium-stainless steel, after first testing mechanical strength in service conditions.
Industries:
Automobile - Aviation - Air conditioning - Aluminium fabrication - Household appliances - Electrical engineering - Mechanical engineering.
Main applications:
Pipes, ducts, ventilation and air conditioning systems, heat exchangers.
Automotive systems including radiators, air conditioning, etc.
Fabrication and profiles, frames, chassis.
Electrical appliances, heating systems.
Bus bars, etc.

Procedure for use:
Preparation:
Clean all components to be joined, eliminating fins, rounding off edges, and removing all trace of oxides and grease.
Mix 190 flux with demineralised water to obtain the desired viscosity.
Coat all assembly components with flux, as well as bare filler alloy.
Secure the components if this is necessary to maintain exact clearances during joining operation.
Torch procedure:
Neutral flame or slightly carburising.
Preheat very large parts extensively and at length to about 200°C.
Make sure that components being joined all have the same temperature.
As soon as the flux melts (approx. 500°C) concentrate the heat in the joint area and start melting the E+C filler alloy.
Spread the alloy with continuous movement of the flame. It will flow naturally to the hottest area.
Do not direct flame at the alloy.
Do not overheat. Avoid inhaling the fumes.
Furnace procedure:
The work pieces can be prepared and the E+C alloy deposited several days in advance.
First the water must be evaporated by heating the components to 150°C, either with an infrared heater or a blower. A fume extractor should be used.
The components may now be placed in the furnace. A shielding gas (e.g. dissociated ammonia) is necessary for large components requiring prolonged heating. A furnace temperature of 650°C is recommended.
Other heating methods may be used such as high frequency induction.
Removal of Flux residues:
The flux residues are corrosive, they should be fully eliminated after brazing.
The flux residues are fully soluble in warm water, they can be eliminated by brushing, soaking in warm water followed by rinsing in water. Cleaning, removal and surface oxides can be done by dipping in 10%-20% in weight caustic soda solution, followed by neutralizing in diluted nitric acid. After those operations rinse in water and dry.
Packaging and storage:
Safely stack and store products in a dry location to avoid pick up or damage.
Should be kept out of reach, in a closed container, at temperature below 35°C.

Health and safety:
European Union (EU):

HARMFUL
Contains lithium fluoride.
Harmful by inhalation, in contact with skin and if swallowed.
Wear suitable protective clothing, gloves and eye/face protection.
In case of accident or if you feel unwell, seek medical advice immediately (show the label where possible).
Use only in well ventilated areas.
A safety data sheet according to the directive 91/155/EEC is available.

R20/21/22:
S36/37/39
S45 :
S51 :

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