



TECHNICAL INFORMATION SHEET

AL-BRAZE EC ALUMINUM BRAZING FLUX

DESCRIPTION:

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 915F° to 1115F°. 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.

ACTIVITY RANGE:

915F° – 1115° F (490.5°C – 601.6°C)

FLUX REMOVAL:

Flux residues should be removed after brazing to prevent potential long term corrosion. Flux residue can usually be removed by washing with hot water. If flux has absorbed a large amount of oxides chemical or mechanical cleaning may be required. Proprietary cleaning compounds are available such as Bernite®45, (available from Harris Products Group). Other methods such as steam jet, wire brushing, or mechanical grinding may be necessary for heavily oxidized surfaces.

AVAILABLE CONTAINER WEIGHTS:

1/2 Lb. Jars. 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.

SPECIFICATION COMPLIANCE:

AWS A5.31 FB1A, AMS 3412.

SAFETY INFORMATION:

WARNING: CONTAINS FLUORIDES.

PROTECT YOURSELF AND OTHERS. Read and understand this information.

BURNS EYS AND SKIN. CAN BE FATAL IF SWALLOWED. FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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