



Shri Ram Global Electrochem

## SOLDERING AND BRAZING FLUXES

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### FLX – 4010

#### ALUMINIUM BRAZING POWDER

- ✓ Powder can be used as supplied or mixed with water to form paste.
- ✓ Residues are water soluble.

#### DESCRIPTION

FXL – 4010 is a powder flux for brazing aluminum and aluminum based alloys, with an active temperature range of 350°C – 700°C. It promotes strong braze joints in aluminum alloys, without melting the substrate metal. The flux wets the joining surfaces thoroughly and prevents the entrapment of aluminum oxide inclusions in the joint.

#### DIRECTIONS

FXL – 4010 is formulated for use in powder form or mixed with water to make paste

1. Base metal should be cleaned thoroughly to remove dirt, grease and other impurities.
2. Heat the end of filler metal rod and dip into the flux.
3. At temperature, flux liquefies and flows into the joints, removing surface oxide and impurities.
4. Continue heating until the filler metal melts and fills the joint, producing shiny fillets.
5. Flux residues are completely soluble in hot water.
6. Flux is hygroscopic. Store away from heat and moisture.

#### PHYSICAL PROPERTIES

Form	Powder
Humidity Effect	Hygroscopic
Active Temperature	350°C – 700°C

Store Flux in cool, un-humid environment in a tightly sealed container.

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