



NITRAL 1251

Classification selon norme : EN1045 / -FL20

ISO 9001
ISO 14001
BUREAU VERITAS
Certification



APPLICATION FIELD

NITRAL 1251 was formulated for the brazing of aluminium parts or heat exchangers clad with Aluminium/Silicone by the C.A.B. process (Controlled Atmosphere Brazing).

This flux is recommended to Aluminium alloys (5000 serie).

CHARACTERISTICS, CHEMICO-PHYSICAL PROPERTIES

Formulated with a mix of fluoro-aluminates, which ensures the brazing at high temperatures.

White powder
Odourless
On-set melting point : 563-572°C
Bulk density 0,60 +/-0.01
pH 6 – 7 (10% solution in distilled water)
Ignition loss (550° C) < 3 %

Flux characteristics:

K: 25-33%
Al: 14-19%
F: 45-55%

DIRECTION FOR USE

After degreasing, the parts to be brazed are fluxed by dipping or spraying, then dried at circa 300° C (575° F).

After preheating the parts, they are brazed in a furnace at 600 – 605° C (1112° F – 1121° F), this step is followed by a cooling stage.

The brazed parts are perfectly clean and without corrosive residues. No additional cleaning is necessary.

Settings and quantities of flux to be applied, must be determined by your technical department during the set-up and preparation of the fluxing solution.

To keep a stable solution, the flux bath must be continuously stirred.

PACKAGING

Kraft drum of 25 Kg.

MISCELLANEOUS

All active materials are in compliance with REACH.

Refer to MSDS (Health and Safety data sheet) – available on demand.

Note: The contents of this data sheet result from our knowledge and experience of the product. It is given as an indication but does not engage our responsibility for each particular case.