

Handy Flux® A-1

GENERAL DESCRIPTION

Handy Flux A-1 is water based active chloride/fluoride/borate-type flux in paste form, which has been specially formulated to give excellent adhesion when dipped or brushed on parts. It is recommended to use with filler metals that flow between 1100°F (593°C) - 1600°F (871°C). The flux provides excellent protection of parts up to 1600°F (871°C).

PRODUCT APPLICATION

Handy Flux A-1 is primarily used as a general purpose brazing flux in brazing applications involving brazing of aluminum bronze, aluminum silicon and other ferrous and non-ferrous alloys containing small amounts of aluminum or titanium. It is not recommended for use in brazing of titanium or aluminum base metals. Handy Flux A-1 is suitable for use with most heating methods including torch, induction or furnace. This product exhibits excellent adhesion, less spattering and oxide removal capabilities during brazing process. Handy Flux A-1 may be thinned with water to a smooth uniform consistency for brushing or dipping. The product exhibits excellent shelf life if stored in a dry place between 65°F (18°C) - 75°F (24°C). If stored for a long period of time some separation within the flux may occur. In such case stir the flux up until proper consistency is restored.

POST CLEANING

This product is corrosive and a post braze cleaning or rinsing operation is required. The flux residue is easily dissolved in hot water at temperatures of 120°F (49°C) or higher.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Dry Fluxes for twelve months from the date of shipment if stored in the original, unopened container. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry with a relative humidity of 50% or lower. It is not uncommon for the dry flux constituents to aggregate overtime. This has, however, not shown to affect the performance of the dry flux products.

Twelve months should not be interpreted as the shelf or useful life of the product unless actual test results indicate unsatisfactory performance for the intended application.

AVAILABLE PACKAGING

Handy Flux is available in a variety of packaging options including 1/2 lb, 1 lb, 5 lb, 25 lb and 50 lb containers.

SPECIFICATIONS

Handy Flux A-1 conforms to the following specifications:

- American Welding Society (AWS) A5.31 FB4A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-054.

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for Handy Flux A-1.

WARRANTY CLAUSE

Lucas-Milhaupt, Inc. believes the information contained herein to be reliable. However, the information is given by Lucas-Milhaupt, Inc. without charge and the user shall use such information at its own discretion and risk. This information is provided on an "AS IS" AND "AS AVAILABLE" basis and Lucas-Milhaupt, Inc. specifically disclaims warranties of any kind, either express or implied, including, but not limited to, warranties of title or implied warranties of merchantability or fitness for a particular purpose. No oral advice or written or electronically delivered information given by Lucas-Milhaupt, Inc. or any of its officers, directors, employees, or agents shall create any warranty. Lucas-Milhaupt, Inc. assumes no responsibility for results obtained or damages incurred from the use of such information in whole or in part.