

Handy One[®] Storage Statement

GENERAL DESCRIPTION OF HANDY ONE FLUX CORED ALLOYS

Handy One is a trademark for a family of flux-cored brazing materials that offer numerous advantages compared to traditional metal joining methods. It consists of a filler metal in strip form that is rolled around a powdered flux. Formulations currently exist for silver (and aluminum based) brazing filler metals and it is available on spools, coils or rods for wire feed applications and as preformed rings and shapes for automated production lines.

TYPICAL FLUXES CONTAINED IN HANDY ONE PRODUCTS

Lucas-Milhaupt, Inc has several different fluxes available depending upon the material form (wire or preformed shape) as well as base metals and heating methods utilized.

- **Restrictive Flux** – protects the parts being joined, yet restricts the flow of the filler metal, enabling the building of fillets and minimizing post braze secondary operations. This flux is recommended for most hand feed or wire feed applications. Flux content is typically 12% ($\pm 3\%$) of the total weight.
- **Free Flowing Flux** – This very fluid flux provides excellent protection of your parts and facilitates filler metal flow. Recommended for preformed ring applications, it is typically 18% ($\pm 3\%$) of the total weight.
- **Heat Resistant Flux** – Boron modified flux for large mass assemblies or long heating cycles. It is also typically 18% ($\pm 3\%$) of the total weight and also recommended for preformed ring applications.

Please Note: Flux percentages may vary depending upon material size and finished form, please contact Lucas Milhaupt's Technical Services Department for specific product and process parameters.

STORAGE AND WARRANTY

Until ready to use Lucas-Milhaupt recommends Handy One products remain in the original sealed packaging. Preferably Handy One products should be stored in a clean and dry atmosphere, temperature controlled environment. Optimal storage conditions for Handy One products would 65°F (18°C) - 75°F (24°C) 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.

In cases where further storage information is required, please contact Technical Service Department at 1-800-558-3856 for recommendations to avoid cross contamination of the product.

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 the applicable Handy One product.



Technical Data Sheet

WARRANTY CLAUSE

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