

KX4600SSKNC

GENERAL DESCRIPTION

KX4600SSKNC is a non-corrosive premixed flux slurry adjusted to a stable dispensing viscosity for brush and dip brazing. It is used in the joining of 1000, 3000, 6000 and some 5000 series aluminum alloys in an open air brazing processes.

KX4600SSKNC slurry is a stable mixture of KX-200 flux, a more reactive non-corrosive flux and an organic vehicle. The slurry contains a proprietary binder that provides adhesion and non-settling properties. It has a melting rang of 1030°F-1070°F (554°C - 577°C). The slurry can be used in atmosphere furnace, torch or induction brazing processes for joining a wide variety of aluminum alloys, especially magnesium containing alloys such as 6061 and 6063. No post braze cleaning operations are required. The flux and its residues are non-hygroscopic and non-corrosive.

PRODUCT APPLICATION

KX4600SSKNC slurry is recommended for use with AL 716 (American Welding Society (AWS) A5.8/A5.8M BAlSi-3) and AL 718 (AWS A5.8/A5.8M BAlSi-4), and AL 719 braze filler metals. If necessary, stir before using to insure proper consistency. Lucas-Milhaupt, Inc. flux slurry can be thinned with alcohol.

POST CLEANING

KX4600SSKNC contains a non-corrosive flux and requires no post braze cleaning operation; however, if it is desired to remove the residue, a 50/50 mixture of nitric acid and distilled water will suffice. Agitate the part in the solution for 30 seconds to remove all flux.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their slurry products for 90 days 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. It is recommended that the slurry products are stored away from direct heat. Slurry may require mixing to regain a homogenous mixture before application.

The 90 day warranty should not be interpreted as the shelf or useful life of the product. Slurry may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

AVAILABLE PACKAGING

KX4600SSKNC aluminum flux slurry is available in a variety of packaging containers.

SPECIFICATIONS

KX4600SSKNC conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 84-398.

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. KX4600SSKNC.

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.