

X6346

GENERAL DESCRIPTION

X6346 is an aggressive, chloride based flux system designed for use with aluminum brazing filler metals for joining of 1000, 3000, 6000 and some 5000 and 7000 series aluminum alloys in an open air brazing processes. This dispensable flux consists of an exclusive combination of fluoride and chloride salts and an inert binding agent to hold it in suspension. This product is corrosive and the flux residue must be removed from the assembly following the brazing operation.

X6346 removes surface oxides that form on aluminum, which allows for excellent melt and flow characteristics of the filler metal. This product has been formulated to provide consistent dispensing features from either manual or automatic dispensing equipment.

Some of the performance advantages of X6346 include:

- This product will not separate, and therefore does not require mixing
- Low to no spatter characteristics
- Reduced flux consumption through controlled application of the product
- Proper post braze cleaning or rinsing with water will eliminate acid post clean-up procedures

This flux system is recommended for use in an open air or torch heating applications. It does not require drying prior to brazing and will remain in place and not flake off or blow off the assemblies during the heating cycle of the brazing process.

PRODUCT APPLICATION

X6346 becomes fully molten and active by 1000°F (538°C). It 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) braze filler metals in a ring or wire form.

BRAZING CHARACTERISTICS

X6346 will exhibit some restrictive slump characteristics and can be used on vertical joints. This product is corrosive and a post-braze cleaning or rinsing operation is required.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Brazing and Soldering Paste 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 paste products are stored away from direct heat. Paste 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. The paste products may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

AVAILABLE PACKAGING

Handy Flo and DF products are available in various size syringes, jars and cartridges. Dispensable flux may also be obtained in large containers prepackaged for immediate pneumatic dispensing operations.

SPECIFICATIONS

X6346 conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-102.

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 X6346.

WARRANTY CLAUSE

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