

# Product Information

## Aluminium Soft Solder Flux

**Flux for the soft soldering of aluminium and aluminium alloys**

**Item No. 245100..**

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All information about our products is the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

## Description

Flux for the soft soldering of aluminium, aluminium alloys and copper.

## Properties

Type:	2124 according to EN ISO 9454-1:2016
Condition:	viscous / like honey
Density (20° C):	1.3 g/cm <sup>3</sup>
Operating temperature:	180 - 300° C
Colour:	clear yellow

## Application

After the soldering point has been cleaned of coarse impurities and grease, spread our aluminium soft soldering flux onto the points to be connected before soldering. After the required soldering temperature has been reached, the solder is fed in. **Warning: above 300 ° C the flux will carbonize!** In the case of large-volume components, it makes sense to first heat the component without flux, dip the solder wire into the flux and then lead it to the soldering point. Heavily oxidized aluminium should be sanded before soldering.

Also suitable for the soldering of GALFAN®- (95 % zinc, 5 % aluminium) coated steel sheets in connection with Sn60Pb40. As standard soft solder for application on aluminium we recommend the alloys Sn90Zn10, Sn99,3Cu0,7 and Sn97Cu3.

The flux residues are corrosive and have to be thoroughly removed with water after the soldering process. Soft solder joints on aluminium are generally not very corrosion-resistant. For applications in humid atmosphere or outdoor area a surface finishing or coating is essential!

## Advices

**Storage and shelf life:** Storage at temperatures as constant as possible between + 5 ° C and + 20 ° C is recommended. Under these conditions, shelf life in the original unopened container is 24 months.

**Handling:** Reference is made to the associated safety data sheet.

## Delivery Form

30 g bottle with brush insert  
 0.100 kg, 0.250 kg, 0.500 kg, 1.000 kg bottle  
 Other package sizes and bulk packs are deliverable on request.