

# Product Information

## Aluminum Brazing Flux Powder No. 1

Brazing flux for Aluminum and Aluminum alloys with a activity range of 480 - 750 °C  
Type FL 10 according to DIN EN 1045

Item-No.: 264000 ...

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All information about our products are 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

**FELDER Aluminium brazing flux powder No.1** is a flux on a basis of hygroscopic chlorides and fluorides especially lithium combinations for hard soldering and welding of pure aluminium and aluminium alloys with a working temperature of 590 – 660 °C.

## Properties

Formation	:	powder
Working temperature range	:	480 - 750 °C
Colour	:	white

## Application

The solder and the soldering respectively welding joints have to be cleaned thoroughly. Before you apply the hard soldering powder it has to be mixed with water, till it becomes a paste.

Depending to the application area the following Aluminium rods according DIN 1732 can be used:  
S-Al99,5, S-Al99,5 + Ti, S-AlMg3, S-AlMg5, S-AlMg4,5Mn, S-AISi5, S-AISi12

## Residues

The flux residues are corrosive and, therefore, have to be removed with water or caustic.

## Delivery forms

0,100, 0,250, 0,500, 1,000 kg bottles

## Storage advices

Store in tightly closed containers protected by humidity, insolation and warmth effect.

## Minimum durability

24 months from production date.