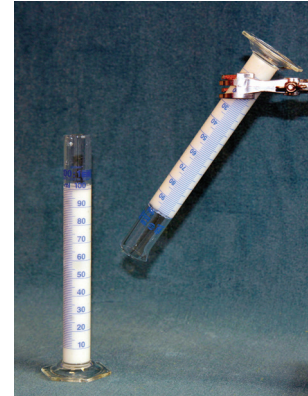


HONEYWELL AL-FLUX CONCENTRATES

Benefits:

- Honeywell AL-Flux Concentrates contain predispersed flux particulates together with surfactants and dispersants in an aqueous gel.
- HONEYWELL AL-FLUX 2805-600 can be stored in a similar way to powder because it does not flow or sediment under the influence of gravity. On the other hand, the thixotropic characteristics allow the gel to be pumped and mixed for further dilution, just as in any other liquid system.
- HONEYWELL AL-FLUX 2805-600 saves time because as a predispersed flux in water it can be rapidly mixed with more water and diluted to the required flux concentration.
- HONEYWELL AL-FLUX 2805-600 improves working and safety conditions by a wet-in-wet production process preventing dust formation.
- HONEYWELL AL-FLUX 2805-600 contains Honeywell KAIF4 flux, a unique multi-constituent phase material with amorphous amounts providing a lower melting temperature, allowing up to 20% extra time for full surface wetting, improved cleaning and more complete oxide removal before filler metal melts. This ensures the best possible braze joint preparation and filler metal flow.
- HONEYWELL AL-FLUX 2805-600 can be enhanced by HONEYWELL CsAlF4 or other additives.



Product Data Sheet

Article Designation:	HONEYWELL AL-FLUX 2805-600
Description:	Non-corrosive, predispersed flux concentrate as aqueous paste
Main use:	In diluted form for wet fluxing or as component in paint flux formulations
Method of Application:	Shower, spray, roller or dip fluxing

Typical Physical Properties

Appearance	White paste
Flux Content	60 wt%
Boiling Temperature	100°C
Onset of melting	549 – 560 °C (max. 560°C)
Density	1.65 kg/l

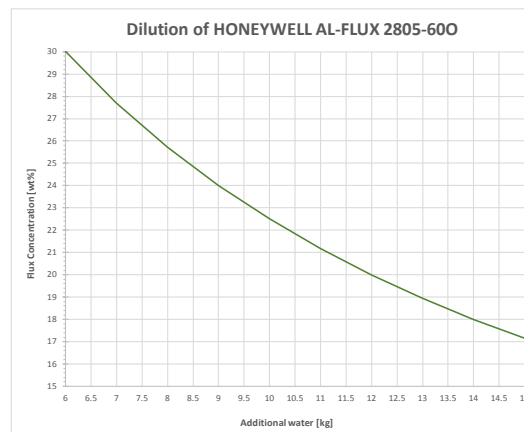
Typical Chemical Properties (Flux)

K	29-34 %
Al	14-18 %
F	47-53 %

Non-Corrosive Al-Flux Concentrates are classified as irritant according to current regulations. Observe usual chemical handling precautions. Please see Material Safety Data Sheet (MSDS) for additional information.

Application

- HONEYWELL AL-FLUX 2805-600 can be used where fluxing of aluminium components by shower, spray, roller or dip coating is required.
- It can replace most flux powder operations where dust generation is a concern or where an easy and flexible fluxing process is required. The flux particles have been isolated and well dispersed in water therefore enhancing their tendency to stay in suspension, even after dilution.
- HONEYWELL AL-FLUX 2805-600 can be diluted to concentrations less than 60 wt% by adding deionized water and mixing.
- Agitation with low-cost equipment is sufficient to generate an homogenous dispersion.
- The mixing can be easily carried out in the supplied 20l package. The required amount of water for a given target concentration can be extracted from the graph.
- Complete homogeneity can be achieved in 10 minutes using a gyroscopic mixer.
- Apply 3 - 10g/m² flux by spraying with an air gun.
- If shower fluxing is used an excess of flux can be removed with an air knife thus minimizing unwanted post braze residue.



Preparation guide for a 20 wt% solution

- Select the 20 w% target on the vertical axis.
- Determine the required amount of water on the horizontal axis (12 kg).
- Open 20 l pail with 6 kg flux concentrate
- Add 12 kg of deionized water
- Close lid and mix pail well.
- Agitation time in a gyroscopic mixer 10 min
- After mixing the suspension is ready for use

Appearance of Packing

Type	Net Weight	Dimensions
Plastic pail, PP, wide opening	25 kg	460 x Ø 289
Suitable for mixing on demand, e.g. using a gyroscopic mixer	6 kg	
Bulk package on request		



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For more information

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2910 A4 | May 2018
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