



DuraBraz® Controlled Atmosphere Brazing (CAB) Flux

DuraBraz[™] flux is an engineering material, which has been formulated specifically for "Controlled Atmosphere Brazing (CAB) of aluminum heat exchanger components. DuraBraz[™] flux is fully compatible with today's CAB brazing equipment and aluminum brazing alloys. DuraBraz[™] is a cost effective, non-corrosive brazing flux custom designed for CAB brazing radiators, condensers, evaporators, heater cores or change air coolers.

DuraBraz[™] is a fused salt with as chemical formulation based upon the potassium fluoride + aluminum fluoride system (see KF+AlF₃ phase diagram on page 2). With reference to the phase diagram, there is a low melting point, eutectic region located at 45 and 50-mole % AlF₃, which has a melting range of 565-577 ° C, ideal for today's aluminum brazing alloys. On the basis of this system DuraBraz[™] is manufactured as fused fluoroaluminate salts consisting of K₃AlF₆ and KAlF₄, formulated to yield this same low temperature, 565-577 ° C, eutectic composition.

Physical Chemical Properties	
Appearance	White crystalline powder
Solubility in H ₂ O at 25°C	.25 gm per 100 ml
Density	2.7 g/cm ³
Melting Point	565-577°C

Packaging

Fibre drum with polyethylene liner 50 and 200 net lbs. Custom packaging available by request

Specifications	
K ₃ AlF ₆ & KAlF ₄	Matrix
Fe	0.03 max.
Particle Size	Less than 50 microns

