

Meta-Braze™ ALC 31 Flux Powder

Aluminium Brazing Flux

Meta-Braze™ ALC 31 is an aluminium brazing flux formulated for brazing of aluminium using an aluminium-silicon brazing alloy such as Meta-Braze Al 112 / BAlSi-4. Meta-Braze™ ALC 31 is a flux powder which can be mixed into a water-based paste. It is suitable for automotive and aerospace applications and for the manufacture of aluminium heat exchangers.

Meta-Braze™ ALC 31 Flux may be used for torch or induction brazing operations in air. This flux is corrosive, read the Safety Datasheet before use and wear protective clothing.

Standard	Proprietary	Reference Standard ISO 18496:2020 FL10 A	
Melting Range	N/A	Working Range: 550-650°C	
Chemical Composition	Proprietary – contains metal chlorides and fluoroaluminates		
Conditions for Use	<p>Remove surface contamination from the parts to be brazed and ensure parts are free from oil and grease; surface oxide should be mechanically removed.</p> <p>Flux powder should be mixed into a thick paste before applying to the components using water and a couple of drops of liquid detergent. A layer of flux paste should be applied to the joint surfaces using a suitably sized paint brush. If using a preform braze ring apply some flux to the ring when it is in position.</p> <p>Recommended heating processes are flame and induction brazing. Parts should be heated to brazing temperature when the flux will be a clear / opaque colour. Braze alloy rod can then be applied taking care not to heat it directly. N.B. The flux residues of this product are corrosive. First spray or dip hot parts in cold water. Then rinse with hot water. A dilute nitric acid pickle might be necessary to remove all residues. Finally rinse the parts in hot and then cold running water and dry.</p>		
Physical Properties	The flux is an active and corrosive product please read safety instructions before use.		
Forms of Supply	Powder or water-based paste		