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TBM 12 NCs

ALUMINUM

DESCRIPTION

Bare rod consisting of a homogeneous mixture of aluminum alloy and a non-corrosive flux for **high-strength** brazing of sheet, forged or cast parts in aluminum alloys.

CHARACTERISTICS

- **No other flux required**
- 14% non-corrosive flux content
- Low bonding temperature
- Easy and quick application
- No post-braze cleaning required
- High fluidity and good wettability
- Can be used with a torch, in an oven or by induction
- High mechanical resistance
- Excellent electrical conductivity
- Good colour match on aluminum

TYPICAL APPLICATIONS

Aluminum parts repair, aluminum connectors, heat exchanger, air conditioning and refrigeration systems, connection of pipe aluminum, radiators, automotive etc. **Not recommended for aluminum-magnesium alloy.**

PROCEDURE

Clean the brazing area and remove grease and dirt. Heat uniformly using a low carburizing flame. When the temperature of liaison is obtained, melt the alloy in the joint by heating until it has completely penetrated.

MECHANICAL PROPERTIES

Tensile strength:	20 305 psi (140 MPa)

BRAZING PARAMETERS

Diameter:	2.5 mm (3/32"), 2.0 mm (5/64''), 1.6 mm (1/16") and 1.2 mm (0,045'')
Bonding temperature:	575°C - 585°C (1067°F - 1085°F)
Type of flame:	Slightly carburizing

Also available in wire and preformed rings.

Rév.: 13_03

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