

330F FLUX

GENERAL DESCRIPTION

330F is a water soluble, inorganic alkali chloride and fluoride containing flux and should be used only in well-ventilated areas. This flux system is designed for use with aluminum brazing filler metals for joining of 1000, 3000, 6000 and some 5000 series aluminum alloys in an open air brazing processes. Avoid breathing fumes produced in brazing.

PRODUCT APPLICATION

330F is an aluminum brazing flux – paste, formulated for use with conventional automated dispensing equipment. It is a stable, dispensable slow-drying paste flux for brazing aluminum and aluminum based alloys that is highly corrosive and non-settling. 330F promotes strong braze joints in aluminum alloys without melting the substrate metals.

330F becomes fully molten and active by 1000°F (540°C). It is used with AL 716 (American Welding Society (AWS) A5.8/A5.8M BAISi-3), AL 718 (AWS A5.8/A5.8M BAISi-4), and AL 719 braze filler rod, wire or preforms in torch, induction and furnace application. Flux residues are completely soluble in hot water.

POST CLEANING

330F is corrosive and a post-braze cleaning or rinsing operation in distilled or deionized water at above 120°F is required.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Brazing and Soldering Paste products for 90 days from the date of shipment if stored in the original unopened container. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry. It is recommended that the paste products are stored away from direct heat. Paste may require mixing to regain a homogenous mixture before application.

The 90 day warranty should not be interpreted as the shelf or useful life of the product. The paste products may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

AVAILABLE PACKAGING

330F is available in a variety of packaging containers.

SPECIFICATIONS

330F conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-137

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for 330F Flux.

WARRANTY CLAUSE

Lucas-Milhaupt, Inc. believes the information contained herein to be reliable. However, the information is given by Lucas-Milhaupt, Inc. without charge and the user shall use such information at its own discretion and risk. This information is provided on an "AS IS" AND "AS AVAILABLE" basis and Lucas-Milhaupt, Inc. specifically disclaims warranties of any kind, either express or implied, including, but not limited to, warranties of title or implied warranties of merchantability or fitness for a particular purpose. No oral advice or written or electronically delivered information given by Lucas-Milhaupt, Inc. or any of its officers, directors, employees, or agents shall create any warranty. Lucas-Milhaupt, Inc. assumes no responsibility for results obtained or damages incurred from the use of such information in whole or in part.