

## KX3641SSKNC

### ***NOMINAL COMPOSITION***

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Aluminum	Remainder
Copper	4.0% ± 0.7%
Silicon	10.0% ± 0.7%
Zinc	10.0% ± 0.7%
Other Elements (Each)	0.05% Max
Other Elements (Total)	0.15% Max

### ***PHYSICAL PROPERTIES***

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Color	Grayish-White
Melting Point (Solidus)	960°F (516°C)
Flow Point (Liquidus)	1040°F (560°C)
Brazing Range	1040°F - 1060°F (560°C - 571°C)
Specific Gravity <sup>(1)</sup>	2.91
Density (Lbs/in <sup>3</sup> ) <sup>(1)</sup>	0.105

<sup>(1)</sup>Metal Only

### ***PRODUCT USES***

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KX3641SSKNC paste is a stable mixture of aluminum silicon filler metal and KX-200 flux, a more reactive non-corrosive flux. The paste can be used in atmosphere furnace, torch or induction brazing processes for joining a wide variety of aluminum alloys. No post braze cleaning operations are required. The flux and its residues are non-hygroscopic and non-corrosive.

KX3641SSKNC paste is a premixed brazing paste adjusted to a stable dispensing viscosity for all automatic and hand dispensers. If necessary, stir before using to ensure proper consistency. KX3641SSKNC brazing paste can be thinned with alcohol.

KX3641SSKNC can also braze aluminum to copper. When joining dissimilar metals, thought should be given to the galvanic potential between the metals to avoid galvanic corrosion problems. To maintain joint integrity on heat treatable aluminum alloys, the solution temperature must be below the solidus of the filler metal. This alloy is not recommended for vacuum brazing due to its zinc content. To prevent liquation, it is recommended that the parts be heated rapidly through the solidus-liquidus temperature range.

### ***PROPERTIES OF BRAZED JOINTS***

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The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design, metallurgical interaction between the base metal and the filler metal. Joint clearances of 0.003 - 0.006 in. per side are optimum for achieving highest joint strength. Joints with increased clearances can still produce adequate joint strengths depending on final operating conditions.

### ***POST CLEANING***

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KX3641SSKNC contains a noncorrosive flux and requires no post braze cleaning operation; however, if it is desired to remove the residue, a 50/50 mixture of nitric acid and distilled water will clean residue. Agitate the part in the solution for 30 seconds to remove all flux.

## ***AVAILABLE PACKAGING***

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KX3641SSKNC aluminum brazing paste is available in various size syringes, jars and cartridges.

## ***SPECIFICATIONS***

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Aluminum powder chemistry is manufactured in accordance to the following specifications:

- Alcoa 719
- AA 4048

## ***APPLICABLE PRODUCT CODE(S)***

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The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 84-394/62-719/40A1.

## ***SAFETY INFORMATION***

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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 KX3641SSKNC.

## ***WARRANTY CLAUSE***

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