

KX4200SSKNC

NOMINAL COMPOSITION

Aluminum	Remainder
Silicon	10.0% ± 1.0%
Iron	0.8% Max
Copper	0.3% Max
Titanium	0.2% Max
Other Elements (Each)	0.1% Max

PHYSICAL PROPERTIES

Color	Grayish-White
Melting Point (Solidus)	1070°F (577°C)
Flow Point (Liquidus)	1095°F (591°C)
Brazing Range	1095°F - 1120°F (591°C - 604°C)

PRODUCT USES

KX4200SSKNC 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 controlled atmosphere furnace, torch or induction brazing processes for joining a wide variety of aluminum alloys, especially magnesium containing aluminum alloys such as 6061 and 6063. No post braze cleaning operations are required. The flux and its residues are non-hygroscopic and non-corrosive.

KX4200SSKNC paste is a premixed brazing paste adjusted to a stable dispensing viscosity for all automatic and hand dispensers. If necessary, stir before using to insure proper consistency. Lucas-Milhaupt, Inc. brazing paste can be thinned with alcohol.

The optimum filler metal to flux ratio depends on brazing atmosphere and heating rate. Lucas-Milhaupt, Inc. will blend special mixes to each customer's unique brazing operation.

PROPERTIES OF BRAZED JOINTS

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

KX4200SSKNC 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 remove residue. Agitate the part in the solution for 30 seconds to remove all flux.

AVAILABLE PACKAGING

KX4200SSKNC aluminum brazing paste is available in various size syringes, jars and cartridges.

SPECIFICATIONS

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

- AWS A5.8 BALS_i-5
- QQ-B-655 (FS-BALS_i-5)
- Alcoa 714
- AA 4045

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 84-387.

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 KX4200SSKNC.

WARRANTY CLAUSE

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