

KX4300SSKNC

NOMINAL COMPOSITION

Aluminum	Remainder
Silicon	7.5% ± 0.7%
Iron	0.8% Max
Copper	0.25% 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)	1142°F (617°C)
Brazing Range	1142°F - 1160°F (617°C - 628°C)

PRODUCT USES

KX4300SSKNC 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.

KX4300SSKNC 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 (0.076 mm - 0.152 mm) 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

KX4300SSKNC 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.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Dispensable Flux 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 dispensable flux products are stored away from direct heat. Dispensable fluxes 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. Dispensable fluxes may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

AVAILABLE PACKAGING

KX4300SSKNC 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-2
- QQ-B-655 (FS-BALS_i-2)
- Alcoa 713
- AA 4343

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 84-388.

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 KX4300SSKNC.

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.