

## LTB3541SSKNC

### ***NOMINAL COMPOSITION***

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Aluminum	Remainder
Silicon	10.0% ± 0.7%
Copper	4.0% ± 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)	970°F (521°C)
Flow Point (Liquidus)	1085°F (585°C)
Brazing Range	1060°F - 1120°F (571°C - 604°C)
Specific Gravity <sup>(1)</sup>	2.71
Density (Lbs/in <sup>3</sup> ) <sup>(1)</sup>	0.098

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

### ***PRODUCT USES***

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LTB3541SSKNC is a stable mixture of aluminum silicon filler metal and NOCOLOK<sup>®</sup> flux, a non-corrosive flux for aluminum brazing. 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.

LTB3541SSKNC 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***

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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 (0.076 mm) - 0.006 in (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***

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LTB3541SSKNC paste 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***

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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***

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LTB3541SSKNC 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:

- Aluminum Association (AA) 4145
- American Welding Society (AWS) A5.8/A5.8M BAlSi-3
- Aerospace Material Specification (AMS) 4184

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

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The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-131/62-718/41A1.

## ***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 LTB3541SSKNC.

## ***WARRANTY CLAUSE***

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