

## X6857 Flux Coating (Handy Flux 1166A Coating)

### ***GENERAL DESCRIPTION***

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X6857 Flux Coating is a moderate fluidity general purpose fluxing system. When used with appropriate silver bearing braze filler metal, X6857 Flux Coating will provide sufficient fluxing action to join most ferrous and non-ferrous metals providing high strength and hermetically sealed joints. The coating is pre-applied and supplied in a flux-coated braze preform.

This system is recommended for use in most brazing applications including torch, induction, resistance and air furnace heating methods. Like all silver brazing fluxes X6857 Flux Coating is not recommended for use in a vacuum brazing operations. In controlled atmosphere brazing applications where a flux is required to supplement a marginal atmosphere, or an alloy containing Zn, X6857 can be used to minimize the detrimental effects of flux to the furnace by providing a controlled volume of flux to achieve proper filler metal wetting and flow. This product is an active flux system with a life at temperature similar in comparison to other available low temperature flux systems.

### ***PRODUCT APPLICATION***

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X6857 Flux Coating is used in conjunction with a braze preform. It is recommended for use with braze filler metals that flow between 1100°F - 1500°F (593°C - 816°C). This product is recommended for use with many of the common Silvaloy<sup>®</sup> formulations which include silver, copper, zinc and tin or nickel, and Easy-Flo<sup>®</sup> alloy formulations which include silver, copper, zinc and cadmium. X6857 Flux Coating has been used in various applications including electronic/electrical, automotive, plumbing, and construction industries.

When used with a flux-coated preform, this product will provide the optimum amount of flux required to create a quality braze joint. This minimizes excess flux and keeps post-braze cleaning to a minimum.

### ***BRAZING CHARACTERISTICS***

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X6857 Flux Coating is corrosive and a post-braze cleaning or rinsing operation is required. The flux residue is easily dissolved in hot water at temperatures of 120°F (49°C) or higher.

### ***WARRANTY & STORAGE***

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Lucas-Milhaupt, Inc. warrants their flux coated preform for twelve months from the date of shipment if stored in the original, unopened and sealed bag. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry with a relative humidity of 50% or lower.

Twelve months should not be interpreted as the shelf or useful life of the product unless actual test results indicate unsatisfactory performance for the intended application.

### ***AVAILABLE PACKAGING***

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X6857 Flux Coating is a coating that is applied to a braze preform. Therefore, it is only available when ordering flux-coated preforms.

### ***SPECIFICATIONS***

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X6857 Flux Coating conforms to the following specifications: *N/A*\*

*\* X6857 flux coating uses a powdered flux which is based on AWS A5.31 FB3F*

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

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The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 84-413.

## ***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 X6857 Flux Coating.

## ***WARRANTY CLAUSE***

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