NOCOLOK® Flux Paste

NOCOLOK®

Physical Properties

Appearance:	white
Flash Point:	N/A
pH:	neutral
Odor:	slight
Density:	1.1 – 1.4 g/cm^3
Specific Gravity:	0.900 – 0.910
Viscosity:	as required

Melting Point*: 565 – 572 °C
refers to NOCOLOK® Flux

*Addition of $CsAlF_4$ will reduce melting point.

Chemical Composition

NOCOLOK® Flux: 15 – 50%
Carrier: Balance
$CsAlF_4$: optional

Viscosity

Can be adjusted to customer specification. Representative example: NOCOLOK® Flux Paste S01-23

Shear Rate (sec^{-1})	Viscosity at 25°C (± 1k mPa·s)
10	4,000
1	17,000

Pseudoplastic behavior

Packaging

10 kg HDPE pail
15 kg HDPE pail

Application

NOCOLOK® Flux Paste is a flux paste specifically formulated for providing a viscous homogeneous mixture of NOCOLOK® Flux (15 – 50 %) in an organic carrier for brazing aluminium cladded interfaces where traditional water based fluxing is not suitable.

Typical applications include but not limited to: interior tube seams (B-tubes), snap over joints (clinch tubes), tube-to-header joints, internal turbulators.

The paste can be dispensed manually by brush or syringe or with automatic dispensing equipment. The paste can be used in both furnace and flame braze process.

$CsAlF_4$ can be added to accommodate materials with Mg of up to approximately 0.5 % in furnace brazing. This refers to the combined Mg-level of both components to be joined.

Li_3AlF_6 can be added to generate a flux residue with further reduced solubility. This minimizes specific interactions that are connected to residue dissolution.

Classification

Classified as hazardous according to the European regulation (EC) 1272/2008 (GHS)

GHS Labelling:
Signal Word: Danger

Hazard Symbols:
GHS07, GHS08

Hazard Statements:
H315, H319, H332, H362, H372, H412

Precautionary Statements:
P260, P263, P273, P280,
P305+P351+P338,
P308+P313, P501

Additional information can be found in the Safety Data Sheet (SDS).

MANAGEMENTSYSTEM

DQS – certified according
DIN EN ISO 9001:2015
IATF 16949:2016
DIN EN ISO 14001:2015
BS OHSAS 18001:2007

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