



## Physical Properties

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

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

\*Addition of CsAlF<sub>4</sub> will reduce melting point.

## Chemical Composition

NOCOLOK® Flux: 15–50%

Carrier: Balance

CsAlF<sub>4</sub>: optional

## Viscosity

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

Shear Rate (sec <sup>-1</sup> )	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 clad 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<sub>4</sub> 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<sub>3</sub>AlF<sub>6</sub> 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

NOCOLOK is registered trademark of  
Solvay Fluor GmbH, Germany

## Solvay Fluor GmbH

Postfach 220

30002 Hannover, Germany

Phone +49 511 857-0

Fax +49 511 857-2146

[www.nocolok.com](http://www.nocolok.com)



**SOLVAY**

asking more from chemistry®

Disclaimer: All statements, information, and data given herein are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, express or implied. Statements or suggestions concerning possible use of our products are made without representation or warranty that any such use is free of patent infringement, and are not recommendations to infringe any patent. The user should not assume that all safety measures are indicated, or that other measures may not be required. In any case, the user is not exempt from observing all legal, administrative and regulatory procedures relating to the product, personal hygiene, and protection of human welfare and the environment.