



Shri Ram Global Electrochem

SOLDERING AND BRAZING FLUXES

FXL – 799

ALUMINUM SOFT SOLDERING FLUX

- ✓ Liquid flux is a high activity flux which helps soldering of Aluminium and it's alloys at low temperatures.
- ✓ Chloride free formulation is an effective flux for joining Aluminium with most ferrous and non-ferrous alloys.
- ✓ Used as supplied, it has excellent coverage and very easy to store and handle.
- ✓ **RoHS compliant product.**

Description

IECCO FXL - 799 is a chloride-free organic activated flux which works at comparatively low temperature with aluminum. IECCO FXL - 799 is highly effective for working with aluminum to copper, aluminum to aluminum, and aluminum to brass or plated terminals. This flux can also be used for hot dip coating.

DIRECTIONS

FXL – 799 can be used with aluminium and it's alloys. It assists most conventional methods of soldering which includes Soldering Iron, Torch and Dip Soldering. The temperature should not exceed 3100C otherwise the flux will char and loss of flux action shall be observed.

Post solder residues can be washed using hot water as the residues are water soluble. Methyl or Iso Propyl Alcohol can be used to cleaning in applications where water needs to be avoided.

Physical Data

Form	Viscous Liquid
Specific Gravity	1.2 ± 5%
Appearance	Clear, transparent to amber viscous liquid
Flash Point	N. A.
pH	10 +/- 0.5
Recommended Soldering Temperature	260 ⁰ C – 300 ⁰ C

HEALTH & SAFETY

While soldering with FXL – 799, it is important to avoid skin contact and/or breathing fumes. It is necessary to do the work in well ventilated area and use of Personal Protective Equipments (PPE) is a must. Because the flux is mildly corrosive to steel, it is recommended to be store in plastic or glass containers. Keep away from sparks, sources of ignition and heat.

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