

TECHNICAL SHEET

AlSi12 D102-M-3

Product name

AlSi12 D102-M-3

Class of product

Aluminium-silicon brazing paste, with non corrosive flux

Corresponding standards of filler metal

| | |
|-------------|---------|
| ISO 17672 | Al 112 |
| EN1044 | AL 104 |
| AWS A5.8-04 | BAISi-4 |

Nominal composition of filler metal (weight %)

| | |
|-----|----|
| Al: | 88 |
| Si: | 12 |

Physical and technical properties

| | |
|-------------------------------|---------------------------|
| Melting range (filler metal): | 590 - 605 °C |
| Metal content: | ~ 30 % |
| Powder grain size: | < 200 µ |
| Flux: | type EN 1045 FL 20 |
| Flux melting range: | 565 – 572 °C |
| Density: | ca. 1,5 g/cm ³ |

Range of application

Silicon-aluminium brazing alloy in paste form.

Suitable to join aluminium and aluminium alloys with max. 0,9% Mg content.

Designed for flame brazing, may be also used for induction brazing.

Flux residues are non-corrosive and may be left on the pieces after brazing.

Directions

Clean carefully and thoroughly the pieces to be joined. They should be free from any contaminant such as dirt, grease, oil, etc.

Apply the paste on the pieces with a little brush or by a dosing system.

Assemble the pieces and let the paste dry.

Heat the pieces gently and uniformly.

As soon as the paste melts and flows, stop heating and let the pieces cool down.

After brazing there is no need of post-braze cleaning of flux residues.

Characteristics Make-up

Paste

Boliden Bergsøe A/S

Hvissingevej 116, DK-2600 Glostrup, Denmark. Danske Bank Account No. 4183 4440363350.
Telephone (+45) 4326 8300. VAT. No. 20862149.
www.boliden.dk, metal.glostrup@boliden.com