

The S.A. Day Mfg. Co., Inc.

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BUFFALO FLUX 2805 FLUX FOR CONTROLLED ATMOSPHERE BRAZING OF ALUMINUM

BUFFALO FLUX 2805 is a non-corrosive brazing flux used to bond silicon clad aluminum resulting in a very clean product.

BUFFALO FLUX 2805 has a melting range of 549⁰-569⁰ C (1022⁰-1055⁰ F).

BUFFALO FLUX 2805 is of high purity Potassium Tetrafluoroaluminate composition.

BUFFALO FLUX 2805 requires a nitrogen controlled atmosphere. The dew point should be maintained at -40⁰ F with an oxygen (O₂) concentration of less than 100 ppm.

BUFFALO FLUX 2805 must be kept in suspension with agitators or constant circulation.

BUFFALO FLUX 2805 may be applied by spraying. It is necessary to dry the fluxed parts prior to entering the atmospheric controlled brazing oven.

Precleaning is necessary prior to flux application. All fabrication lubricants and oils must be removed prior to bonding.

BUFFALO FLUX 2805 does not require post cleaning when proper flux concentration is maintained.

BUFFALO FLUX 2805 is used in a water suspension typically 6 to 25 % by weight depending on the application. The use of S.A. Day Surfactant 5200 is recommended at a rate of 3 mls. per gallon of flux suspension.