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BUFFALO FLUX 2805 LM FLUX FOR CONTROLLED ATMOSPHERE BRAZING OF ALUMINUM

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

BUFFALO FLUX 2805 LM has a melting range of 548^o-565^o C (1020^o-1050^o F).

BUFFALO FLUX 2805 LM is of high purity Potassium Tetrafluoroaluminate and Cesium composition.

BUFFALO FLUX 2805 LM requires a nitrogen controlled atmosphere. The dew point should be maintained at -40^o F with an oxygen (O₂) concentration of less than 100 ppm.

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

BUFFALO FLUX 2805 LM 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 fluxing.

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

BUFFALO FLUX 2805 LM is used in a water suspension typically 6 to 25 % by weight depending on the application.

BUFFALO FLUX 2805 LM can also be applied by electrostatic coating methods because 90% of the particles are less than 15 microns with 100% passing through a 30 micron screen.

Surfactant 5200 is recommended at a rate of 3 mls. per gallon of flux suspension.