

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

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COB CONCENTRATE FOR CONTROLLED ATMOSPHERE AND TORCH BRAZING OF ALUMINUM

COB CONCENTRATE is used to bond silicon clad aluminum resulting in very clean braze joints. Post treatment of brazed parts is not required since it is non-corrosive.

COB CONCENTRATE is ideal for internal braze joints. Example: Tube to header and tank to header.

COB CONCENTRATE is of very high purity Potassium Tetrafluoroaluminate composition plus carrier.

Furnace brazing of silicon clad aluminum alloy requires a nitrogen controlled atmosphere with a dew point of -40° F with an oxygen (O_2) concentration of less than 100 ppm.

COB CONCENTRATE should be kept in suspension by agitation, depending on application.

COB CONCENTRATE may be applied with an automatic applicator, brush or S.A. Day packaged 300 ml. applicator bottle.

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

Proper agitation or mixing will insure that the flux concentration is maintained.

COB CONCENTRATE melting activity is 549° - 569° C (1022° - 1055° F).

Braze oven emissions should be exhausted and treated in accordance with federal, state and local regulations.