fontargen brazing by voestalpine

In-Depth Know-How

High quality products for

ALUMINUM SOLDERING APPLICATIONS

High-quality custom-made products for soldering aluminum in the cooling and automotive industries for the production of heat exchangers, air conditioning, cooling and heating systems, white goods, fluid technology and pipes, household and electrical appliances.

Joining solutions from a single source

As one of the leading suppliers of soldering consumables for the highly developed global automotive and refrigeration and air conditioning industries, Fontargen offers customized soldering solutions for a demanding market.

HVACR

AC HVAC Vehicles (Transportation)

Our portfolio is constantly expanding and includes a wide variety of industries:

- Automotive and transportation (AC)
- Fluid technology (Lines/pipes)
- HVACR Industry (Heating Ventilation Air Conditioning Refrigeration)
- White goods (House appliances)
- Battery compartment and management (E-Mobility)

Advantages

- Solution provider, global sales and distribution network
- Comprehensive product portfolio
- Fulfillment of special customer requests, technical support
- ISO 9001 / 14001 – Approvals
- AEO status (Authorized Economic Operator)
- Just in time delivery in all packaging units
- Financial performance

Product range

Aluminum Solder					
Product names	**Alloy**	**Standards**	**Working temperatures**	**Properties**	**Applications**
AF 631 NH	ZnAl2	S-Zn98Al2	382-407 (°C) 720-765 (°F)	Special flux cored wire Cesium based flux (Cs) – Not corrosive	» Soldering of Al and Al/Cu » Repair work on Al
AF 665 NH	ZnAl22	S-Zn78Al22	420-480 (°C) 788-896 (°F)		

Aluminum brazing pastes with integrated flux of Type FL20 acc. to DIN EN 1045 – Color grey – Not corrosive									
Product names	**Alloy**	**ISO 17672**	**AWS**	**EN 1044**	**Viscosity (mPa.s)**	**Removal of flux residues**	**Working Temp.**	**Dosage**	**Applications**
AP47QL/2e	AlSi12	Al 112	BAlSi-4	AL104	14/16.000	Water shower, bath	575-585 (°C) 1067-1085 (°F)	Automatic dispensing, brushing	» All in one product » Typical paste applications » Various joint geometries, repair work » Flame, Induction, CAB
AP48QL/2e	AlSi10	Al 110	BAlSi-5	AL103	10/12.000		575-590 (°C) 1067-1094 (°F)		
AP49QL/2e	AlSi7	Al 107	BAlSi-2	AL102	14/16.000		575-615 (°C) 1067-1139 (°F)		

Aluminum brazing alloys					
Product names	**Alloy**	**Standards**	**Working temperatures**	**Properties**	**Applications**
A 407 L	AlSi12	ISO 17672 = Al 112 AWS = BAlSi-4 EN 1044 = AL104	575-585 (°C) 1067-1085 (°F)	Solid wire - Use with additional flux of the F400 series - Delivery form and dimensions on request	Brazing of Al Mg - content <0.7 % with non cor. flux (FL20) <3.0 % with cor. flux (FL10)
AF 407 LIB				Standard Flux cored wire Flux content: 21% +/- 1.5% Cs (Wt%): 1.5%-2.5% Flux type FL 20 (acc. EN 1045) - Non corrosive	Brazing of Al Mg - content <0.7 %
AF 407 LIS				Special flux cored wire, with additional braze wire inside Flux content: 16.0% +/- 1.5% Cs (Wt%): 1.5% Flux type FL 20 (acc. EN 1045) - Non corrosive	Brazing of Al Mg - content <0.7 % More stability during heating process. More alloy
AF 407 LIBCs				Special flux cored wire Flux content: 23% +/- 2.5% Cs (Wt%): 18.0%-20.0% Flux type FL 20 (acc. EN 1045) - Non corrosive	Brazing of Al Mg-content < 1.5%
AF 407 LIBCs50				Special flux cored wire Flux conten: 25% +/- 1% Cs (Wt%): not less than 50% Flux type FL 20 (acc. EN 1045) - Non corrosive	Brazing of Al Mg-content <2.0 %

Corrosive white flux pastes and powder - Type FL10 Acc. to DIN EN 1045						
Product names	**Viscosity (mPa.s)**	**Removal of flux residues**	**Activity Temp. Range**	**Deposit**	**Applications**	**Brazing process**
F400 MD-2zGP	36/39.000	Water shower, bath	515-630 (°C) 959-1166 (°F)	Automatic dispensing, brushing	Standard for general flame brazing	Automatic and manual flame brazing. Induktion possible
F400 MD-2zG Thicker	38/42.000					
F400 MD-2zG	35/38.000					
F400 MD-2zG P25T	18/20.000				Large aluminum components	
F400 MP	Powder			N/A	Standard for general flame brazing	

Non corrosive white powder - Type FL20 acc. to DIN EN 1045								
Product names	**Grain size in µm (subject to prior request)**				**Coating area**	**Activity Temp. Range**	**Dosage**	**Applications**	**Various**
	Ultra- fine	**Fine**	**Medium**	**Coarse**					
F400 PD	5-10	8-12	10.5-15	>15	ca. $1m^2/cm^3$	420-560 (°C) 788-1040 (°F)	Dipping, brushing, wet spraying, electrostatic	Furnace brazing of Aluminum - (CAB - Prozess)	» Typically for critical shapes » Cesium complex can be added

Non corrosiv whites pastes - Type FL20 acc. to DIN EN 1045					
Product names	**Applications (Flame, induction, CAB)**	**Visc. (mPa.s)**	**Activity Temp. range**	**Dosage**	**Various**
F400 NH 55	Standard brazing of Aluminum	7.5/9.500 (*)	420-560 (°C) 788-1040 (°F)	Dosing, brushing, spraying	» Typically for critical shapes and/or when the filler metal is in form of a plated layer. » Cesium complex can be added
F400 NH 60		10/13.000 (*)			
F400 NH 55 Cs2	Brazing of aluminum with moderate Mg or Cu content	10/13.000 (*)			
F400 NH 55 Cs4		7/9.000 (*)			

(*)can be adjusted

Non corrosiv white liquid flux - Type FL20 acc. to DIN EN 1045			
Product name	**Activity Temp. range**	**Deposit**	**Applications (CAB)**
F400 Paint Flux	550-560 (°C) 1022-1040 (°F)	Dipping, brushing, spraying	» Standard brazing of aluminum » Drying required before brazing

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