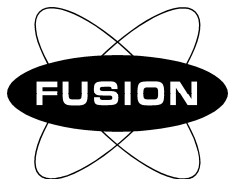




DISPENSABLE FLUX PRODUCTS

Fusion Number	Base Metals	Temperature Range	Recommended Filler Metals	Dispensing Methods	Characteristics	Residue
BRAZING - GENERAL						
DAF-1	Brass, Copper, Steel, Stainless	1000-1600°F	AWS BA _g Series AWS BCuP Series	Fusion Applicators	Restrictive; excellent capillary action; like "White Flux"	Clear, corrosive, must be removed
DAF-1Z	Brass, Copper, Steel, Stainless	1000-1600°F	AWS BA _g Series AWS BCuP Series	Fusion Applicators; also squeeze bottles and brushing techniques	Same as DAF-1 with thinner viscosity	Clear, corrosive, must be removed
DAF-3	Brass, Copper, Steel, Stainless	1000-1600°F	AWS BA _g Series AWS BCuP Series	Fusion Applicators	Restrictive; excellent capillary action; like boron-modified "Black Flux"	Dark, corrosive, must be removed
DAF-3B	Brass, Copper, Steel, Stainless	1000-1600°F	AWS BA _g Series AWS BCuP Series	Fusion Applicators	Same as DAF-3 with thinner viscosity	Dark, corrosive, must be removed
DAF-4	Brass, Copper, Steel, Stainless	1000-1600°F	AWS BA _g Series AWS BCuP Series	Fusion Applicators; also squeeze bottles and brushing techniques	Same as DAF-3B with thinner viscosity	Dark, corrosive, must be removed
BRAZING - CARBIDE						
DAF-5	Carbide to Steel	1000-1700°F	AWS BA _g Series	Fusion Applicators	Restrictive; excellent capillary action	Dark, corrosive, must be removed
DAF-5Z	Carbide to Steel	1000-1700°F	AWS BA _g Series	Fusion Applicators; also squeeze bottles and brushing techniques	Same as DAF-5 with thinner, "dipping" viscosity	Dark, corrosive, must be removed
ALUMINUM – WATER WASHABLE						
DAF-9	Aluminum (3000 & 6000 Series)	700-950°F	All Zinc/Aluminum Solders	Fusion Applicators	Restrictive; excellent capillary action	Water washable, corrosive; must be removed
DAF-10	Aluminum (3000 & 6000 Series)	1000-1190°F	AWS BA _{ISi} Series Brazing	Fusion Applicators	Restrictive; excellent capillary action	Water washable, corrosive; must be removed
DAF-11	Aluminum (3000, 6000 & 5000 Series)	850-1190°F	AWS BA _{ISi} Series Brazing	Fusion Applicators	Same as DAF-10, yet brazes at slightly lower temp.	Water washable, corrosive; must be removed
DAF-11N	Aluminum (3000, 6000 & 5000 Series)	850-1190°F	AWS BA _{ISi} Series Brazing	Fusion Applicators	Same as DAF-10, yet brazes at slightly lower temp. and is non-flammable for shipment by air.	Water washable, corrosive; must be removed
DAF-13	Aluminum (3000 & 6000 Series)	850-1190°F	AWS BA _{ISi} Series Brazing	Fusion Applicators; also squeeze bottles and brushing techniques	Superior capillary action; water cleanup of guns/reservoirs.	Water washable, corrosive; must be removed

Fusion Number	Base Metals	Temperature Range	Recommended Filler Metals	Dispensing Methods	Characteristics	Residue
ALUMINUM - NON-CORROSIVE						
DAF-14	Aluminum (3000 & 6000 Series)	700-950°F	All Zinc/Aluminum Solders	Fusion Applicators	Restrictive; withstands direct heat at final heat station.	Non-corrosive, no post cleaning required
DAF-15	Aluminum (3000, 6000 & 5000 Series)	850-1190°F	AWS BAISi Series Brazing	Fusion Applicators	Restrictive; withstands direct heat at final heat station.	Non-corrosive, no post cleaning required
DAF-16	Aluminum (3000 & 6000 Series)	1000-1190°F	AWS BAISi Series Brazing	Fusion Applicators	Nocolok equivalent	Non-corrosive, reduced white residue, no post cleaning required
SOLDER						
DAF-20	Brass, Copper, Steel, Stainless	300-600°F	All Lead & Lead Free Solders	Fusion Applicators; also squeeze bottles and brushing techniques	Restrictive; excellent solderability at low temperatures; Water clean up of guns and reservoirs.	Corrosive, must be removed.
DAF-30	Brass, Copper, Steel, Stainless	300-525°F	All Lead & Lead Free Solders	Fusion Applicators	Excellent capillary action	Non-corrosive, rosin, no post cleaning required
DAF-40	Brass, Copper, Steel, Stainless	125-450°F	Low-Temp Solders (i.e. indium containing)	Fusion Applicators	Restrictive – use with very low temperature filler metals.	Intermediate to low activity – remove whenever possible.
DAF-41	Brass, Copper, Steel, Stainless	300-600°F	All Lead & Lead Free Solders	Fusion Applicators	Restrictive – stays in place before and during heating.	Intermediate to low activity – remove whenever possible.



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