



TECHNICAL DATA SHEET

# ALUXAL 108

## Covering and drossing-off flux for aluminium foundries



### DESCRIPTION

Aluxal 108 is a powder flux studied for covering and drossing-off treatments of aluminium alloys used in aluminium re-melting shops or foundries producing gravity, low pressure, sand or lost foam castings. Recommended for temperatures of 680-760 °C and for reverberatory, crucible furnaces or transport ladles.

Aluxal 108, when used as a covering flux, creates on the bath surface a barrier between flames and liquid metal reducing oxidation and metal losses.

During drossing-off treatments, Aluxal 108 separates non-metallic inclusions and guarantees the removal of drosses with very low metal content.

Aluxal 108 is not suitable for alloys containing Magnesium >3% and for alloys not tolerating Sodium based fluxes.

**Formation of physical barrier to reduce metal oxidation, reduction of metal losses, drosses with low metal content.**

### PRODUCT PHYSICAL DATA

<b>Appearance:</b>	Crystalline Powder	<b>Colour:</b>	White
<b>Specific Gravity:</b>	1,1 g/cm <sup>3</sup>	<b>Temperature range:</b>	680-760 °C

### METHOD OF USE

- As a cover flux: add enough flux to create a uniform layer on the liquid bath. Generally, the quantity varies between 0,3-0,4 kg per 100 kg of metal. During melting or holding periods, the flux should be left on the bath for total best protection. Before the casting beginning, remove the cover and start with the drossing treatment.
- As a dross-off flux: after the grain refining, degassing and modification treatment, sprinkle 0,3-0,4 kg of Aluxal 108 per 100 kg of metal-on-metal surface. To create maximum contact between flux and drosses we recommend mixing the flux carefully only on the upper part of the bath. The reaction will produce dry, flowing drosses with low metal content. Before pouring or casting, it is advisable to leave the metal resting for a few minutes.

### QUANTITY OF USE

300-400 gr of Aluxal 108 per 100 kg of alloy.

### RANGE OF APPLICATION

Aluxal 108 is recommended for all Aluminium alloys used in die casting and mould.

In case the alloy does not tolerate the presence of sodium, Aluclean 261 is recommended.

Aluxal 108 is studied for melting furnaces, crucibles and transport ladles.

It is not suitable for electric furnaces and dosing furnaces.

The product does not interact with refractory materials or crucibles walls.

An accurate dosage is recommended.

Clean the furnace or crucible wall regularly.

### PACKAGING AND STORAGE

25 kg paper bag laminated with polythene, moisture resistant, heat sealed at the base.

Warnings: The product is hygroscopic, always keep it in dry storage and close the package after each use.

If the product is stored in a dry place away from sunlight, the product does not expire.