

TECHNICAL DATA SHEET

DOUBLE SALT FLUX

(Flux for Hot Dip Galvanizing)

FLUX ; The materials dipped into flux bath before galvanized coating are covered with flux salts. It protects the steel from oxidizing before galvanization. It ensures the steel directly contacts the molten zinc. The flux bath cleans the remaining dirt, iron, oxide, sulphides and sulphates on the steel, preventing them to be carried to the zinc furnace. It reduces the zinc ash and zinc dross. The coating thickness can be reduced significantly. It increases the process speed. It improves the coating quality.

USAGE METHOD

1m³ flux bath is prepared with 450 kg powder flux and 760 kg water. Mixing with a continuous air and similar method into the bath increases the solution efficiency. When the surface coated with Flux is dried at a temperature of 40°C -70 °C, when the piece is immersed in the molten zinc, explosions caused by the sudden evaporation of the water in the Flux is prevented and the formation of zinc oxide is reduced.

PRODUCT SPECIFICATIONS	
Color	White powder
Zinc Chloride	% 55
Ammonium Chloride	% 45
pH	4 – 5
Density	1, 91 gr/cm ³
Boume	-
Refractometer	-

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WORKING CONDITIONS	
Method of Application	Dipping Type
Concentration :	% 35 (by weight)
Working Temperature :	40°C – 70°C
Treatment Time :	60 Second
Zinc Chloride :	% 55 (by weight)
Ammonium Chloride :	% 45 (by weight)
Refractometer :	35
Boume :	26 – 28
pH :	4 – 5,5
Iron :	3 g/lit max.

BATH CONTROL

It is necessary to check pH, Zinc Chloride, Ammonium Chloride, Baume, Refractometer and iron values for the flux bath.

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Note: Baths should be PP or stainless steel, covered with an edge and heat-resistant substances.

TRANSPORT AND STORAGE

- **Flux** It should be stored for a maximum of 2 year in its original packages as 25 kg bag in a closed environment protected from direct sunlight (+4 / +30) in a humidity-free environment. If the product freezes, the drum can be restored by placing it in hot water and mixing it. It should be protected against the risk of high temperature. Transportation activity should be done with vehicles in accordance with the ADR regulation.

PACKAGE

- 25 Kgs Bag

SAFETY PRECAUTIONS

- In case of skin and eye contact, wash with plenty of water. Consult your doctor.
- For more detailed information on the subject, see the product MSDS.

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