



TECHNICAL DATA SHEET

CUPRAL 102

Excellent deoxidant flux for copper alloy containing aluminium



DESCRIPTION

Cupral 102 is a powder flux recommended for coverage and deoxidation treatments of bronzes containing aluminium, silicon or manganese in melting, electric or crucible furnaces. The product stops the aluminium oxidation, raises the mechanical characteristic of the cast and reduces the melting drop. It is indicated for melting in sand casting foundries using crucible furnaces. Cupral 102 melting point is approximately at 850°C.

Anti-oxide fluid cover, reduces build-up of drosses, prevents aluminium loss, increases the fluidity of the cast alloy.

PRODUCT PHYSICAL DATA

| | | | |
|--------------------------|---------------------------|---------------------------|--------------|
| Appearance: | Powder | Colour: | Light brown |
| Specific Gravity: | 1.2-1.4 g/cm ³ | Temperature range: | 1100-1250 °C |

METHOD OF USE

Normally, the recommended quantity for coverage and deoxidation treatments in crucible furnaces is 1kg for 100kg of metal.

If metal charge has high percentage of scraps and ingots (above 30%), it is advisable to increase the quantity of flux.

At the beginning of the melting process, sprinkle the product on the metal surface. Keep the cover intact during the melting cycle.

After melting and when the casting temperature is reached, remove the cover layer and plunge an additional 0.3 – 0.5 kg of Cupral 102 for 100kg of metal.

It is important that the graphite bell is perfectly clean, dry and has no dross layers.

Stir the flux inside the bath carefully.

Carry out the skimming, perform bath deoxidation with Deox and start the casting.

If the liquid dross is difficult to be foamed, add a small of dry sand.

QUANTITY OF USE

The quantity recommended is 1 kg of Cupral 102 per 100 kg of copper alloy.

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.