

Maximum strength, self fluxing solder for joining, build-up and hardfacing aluminum.

- ☐ High zinc content gives good color match to aluminum.
- ☐ No flux required - post cleanup is eliminated.
- ☐ Low working temperature prevents warpage, distortion and discoloration.

INTERNATIONAL SPECIFICATIONS	NONE
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APPLICATIONS:

Ideal for joining aluminum extrusions used in the manufacture and repair of aluminum doors and windows. Also for repairing leaders, gutters, siding, aluminum boats and instrument boxes. Most kirksite and zinc base die castings can be repaired with this alloy. Can also be used as a wearfacing alloy on aluminum.

ALL WELD METAL ANALYSIS (Typical Weight %):

Zn	Al	Cu
11	bal	10

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal

Tensile Strength
Working Temperature
Corrosion Resistance
Color Match

Maximum Value Up to:
36,000 PSI (260 N/mm²)
approx. 710°F (375°C)
Very Good
Very Good

WELDING TECHNIQUES:

Joint area should be thoroughly cleaned, preferably by mechanical means (scraping, filing, etc.). Bevel heavy sections. Use jigs or clamps to hold parts in alignment. With a carburizing flame, heat base metal to approximately 750°F (400°C), rub alloy in the joint. Do not heat rod with flame but let the heat from the part to be soldered melt the rod. Vigorous rubbing of the base metal surface allows the rod to break through the tough oxide and bond to the sound metal. Higher strengths and better bonds may be obtained by using a clean stainless steel wire brush through the molten solder to the base metal surface. Allow part to cool slowly.