

DESCRIPTION

Highly-activated tinning paste for tinning and **soldering** copper, copper alloys and ferrous metals (steel, cast iron, etc.) **at low temperatures.**

CHARACTERISTICS

- Slight deformation
- Paste with active soldering flux
- Quick and easy application
- May be used in difficult-to-reach areas
- Torch, induction or oven application

TYPICAL APPLICATIONS

Car bodies, sheet metal tinning, tinning of parts before the application of "Babbit"; radiator repairs, plumbing, joints, etc.

PROCEDURE

Remove any trace of oil, grease or dirt from the joint. Cover the joint with **Tinwell** tinning paste with a spatula. Heat the torch while moving the flame back and forth about 2" (50 mm) above the joint until the soldering flux begins to darken the surface. Cool slowly to solidify well. After tinning, remove any residue by wiping with a wet cloth or rinsing in warm water. For oven application, the operating temperature must range between 249 - 271°C (480 - 520°F). **Do not use on aluminum, white metal and magnesium.**

MECHANICAL PROPERTIES

Tensile strength: 7 000 psi (48 MPa)

BRAZING PARAMETERS

Bonding temperature: 186°C (370°F)
Type of flame: Neutral

Rév.: 7_01

Specialized welding alloys and technology. For technical assistance or for ordering: