

**DESCRIPTION**

**Tubular** aluminum rod containing a highly-active soldering flux for **brazing** and **building up** aluminum and various aluminum alloys.

**CHARACTERISTICS**

- **No other flux required**
- Multiple uses on any grade of weldable aluminum
- Instantaneous solidification, even in position
- Dense porosity-free and corrosion-resistant deposit
- Very easy bead application
- Good colour match on aluminum

**TYPICAL APPLICATIONS**

Building up and brazing of cast, thin sheet and tubular parts. Motor and transmission parts, aluminum car bodies, parts of various thicknesses, frames, water pumps, etc.

**PROCEDURE**

Clean the brazing area and remove grease and dirt. Gouge heavy parts in V shape at around 60°. Heat rapidly with a moving carburizing flame, while maintaining it at a distance of 2.5 to 7.5 cm (1" to 3") from the metal base. Melt the tip of the rod on the part and heat until the flux becomes fluid. Continue filling the joint melting the alloy in beads. Cool slowly and wash out the flux with warm water.

**MECHANICAL PROPERTIES**

Tensile strength: 35 000 psi (241 MPa)  
 Elongation: 15 - 25 %  
 Hardness: 45 - 60 BH

**BRAZING PARAMETERS**

Diameter: 3.2 mm (1/8")  
 Bonding temperature: 590°C (1094°F)  
 Type of flame: Carburizing

Rév.: 7\_01

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