

ALUBRAZE

UNIQUE FLUX CORED ALUMINUM BRAZING ROD FOR DIRTY APPLICATIONS

TORCH

GENERAL CHARACTERISTICS:

Unique aluminum torch alloy with the highly active flux contained inside the rod where it is protected from contamination. It can be applied in all positions with the oxy/fuel torch. Tungsten inert gas, DC welding machines, and other expensive welding equipment are not needed for the repair of most aluminum parts; therefore this rod fills the needs of many welders both in the shop and field.

APPLICATIONS:

Fabricating, build-up, and repair of all weldable grades of aluminum, including cast alloys. Ideal for joining dissimilar gauges and for poor fit-up applications where a less fluid alloy is desired.

TECHNICAL DATA:

Tensile Strength..... up to 34,000 psi (234N/mm²)
Working Temperature 1100°F (593°C)
Elongation % 15-25
Hardness (HB) 40-55
Color Matchgood (will darken if anodized)
Corrosion Resistance good
Diameter
(in) 1/8"
(mm) 3.25

PROCEDURE:

Remove oxides and foreign material from weld area preferably by mechanical means, (scraping, filing, etc.). Bevel parts thicker than 3/16" (5.0 mm) to form a 60° vee. With the oxy/fuel torch adjusted to a slightly carburizing flame, heat work broadly to about 1000°F (538°C). Melt 1/4" (6 mm) of the rod off onto the workpiece, (the flux will also turn to a liquid); continue heating until alloy flows out. If extra flux is needed, use 8001 flux. Lower the angle of the torch; continue adding alloy a drop at a time until weld is complete. Allow part to cool slowly. Remove all flux residue with stiff brush and hot water.