UNITED ALLOYS
RESEARCH & DEVELOPMENT INC.

125 BLACKSTONE AVE.

JAMESTOWN, NY
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ALUMITE

LOW TEMPERATURE SOLDER FOR ALUMINUM TO ITSELF OR OTHER METALS

ALL HEAT SOURCES

GENERAL CHARACTERISTICS:

A special complex alloy system solder that has excellent wetting and flow characteristics on almost all ferrous and non-ferrous metals. Since it has a “0” plastic range, its strength remains relatively high even at service temperatures up to 350°F (175°C). This solder has better corrosion resistance and higher strength than ordinary soft solders, but the bonding temperature is much lower than the silver brazing alloys, therefore it is the ideal intermediate alloy for joining.

APPLICATIONS:

Aluminum radiators, aluminum tube to copper tube in refrigeration and air conditioning units, sheet metal work, manufacture and repair of instruments, zinc base die casting and joining of dissimilar metals. Also for use on anodized aluminum.

TECHNICAL DATA:

Tensile Strength..... up to 22,000 psi (152 N/mm_2)
Working Temperature ..... 509°F (265°C)
Color Match ..... very good on aluminum
Electrical Conductivity ..... good
Corrosion Resistance ..... good
Diameter (in) 1/16”
(mm) 1.6

PROCEDURE:

Thoroughly clean joint area. For best results, maintain a joint clearance of no more than .006”. Completely cover joint area with ALUMITE flux; heat part with a soft flame being careful not to burn the flux. As soon as flux starts to bubble, dip solder into flux and transfer to joint, continue heating until solder flows through entire joint. Allow to cool slowly. Remove all flux residue with hot water and stiff brush.

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