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# Alloy Braze - Flux cored Aluminum Repair

## 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 an 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 out in the 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 Match .....	good (will darken if anodized)
Corrosion Resistance .....	good
Available Diameters:.....	1/8" (.125), 3/32" (.093), 1/16" (.062)

## PROCEDURE:

Remove oxides and foreign material from weld area preferably by mechanical means, (scraping, filing, wire brush 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 clear liquid); continue heating until alloy flows out. If extra flux is needed, use Alloy Sol powder flux.

Lower the angle of the torch; continue adding alloy a drop at a time until weld is complete. Allow repair area to cool slowly. Remove all flux residue with stiff brush and hot water.