



Flux Cored Aluminum Brazing

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
In accordance with
ISO 9001
Cert # 05-R0925



ALLOY DESCRIPTION AND APPLICATION:

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APPLICATIONS

An all-position, oxyacetylene welding or brazing rod used in repairing broken or cracked aluminum extrusions or castings. Typical applications would include building-up machinable deposits or worn or broken parts, model work, mold/die changes and thin sheet metal.

CHARACTERISTICS

Flux cored aluminum is one of the most versatile torch rods. The self-contained flux offers protection from handling and moisture. A broad operating temperature range and excellent color match makes this alloy suitable for many applications. It offers good plasticity, high strength and is readily machinable.

PROCEDURES

Remove any plating, dirt, grease or surface corrosion from the area to be welded or brazed. Sand and clean the weld area thoroughly. The gap to be welded should not exceed 1/8". Bevel heavy sections to form a 60° to 75° V-notch Using a slightly carburizing flame, heat the work area by keeping the flame 1" to 2" from the weld area. Continue to heat the weld area while occasionally touching the flux cored aluminum rod to this area under the torch flame. Do this until small amounts of alloy are deposited and the filler metal starts to flow through the gap of the heated weld area. Be sure that each drop of filler metal flows out and bonds to the base metal, but do not melt the base metal. Allow the weld part to cool and wash away the flux residue with warm water and a stiff brush.

CHEMICAL COMPOSITION, Weight Percent:

| | |
|-------------------------|---------------|
| Silicon | 3.5-12.5 |
| Copper, Iron, Magnesium | 0.50 max each |
| Aluminum | Balance |
| Total Others Elements | less than 1 % |
| Flux and binder | 2.0-15.0 |

PHYSICAL DATA:

| | |
|---------------|-------------------------|
| Solidus | 1045°F (563°C) |
| Liquidus | 1110°F (599°C) |
| Brazing Range | 1080-1120°F (588-604°C) |
| Color | Aluminum color match |

AVAILABLE SIZES:

TU AL FLUXCORED = 32" Rods 2 ¼ # Tubes of 3/32, 1/8, 3/16
Other sizes available – please inquire

SPECIFICATIONS: INTERNAL

| | | |
|---------------------|------------------------|----------------------------|
| EAST COAST | GULF COAST | WEST COAST |
| 7010-G Reames Rd | 4855 Alpine Drive #100 | 8535 Utica Ave |
| Charlotte, NC 28216 | Stafford, TX 77477 | Rancho Cucamonga, CA 91730 |
| Tel (888) 522-8296 | Tel (877) 711-9274 | Tel(800)830-9033 |
| Fax (704)598-6673 | Fax (281)313-6332 | Fax (909)291-4586 |



WA. ALLOY CO.

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Warehouse Distribution Center – Dallas/Fort Worth, Portland, Oregon & Boston, Massachusetts Head Office – Puyallup, Washington

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