



75

ALUMINUM

DESCRIPTION

Bare rod made up of a **high-strength** and **highly-liquefied** aluminum alloy for brazing thin sheet, forged and cast aluminum alloys.

CHARACTERISTICS

- **Specially designed for dirty or difficult-to-weld aluminum alloys**
- Very high fluidity
- Low bonding temperature
- Can be used with a torch or TIG process
- High mechanical resistance
- Excellent electrical conductivity
- Good color match on aluminum

TYPICAL APPLICATIONS

Pipes, refrigeration, body work ("hot roads"), radio instruments, aluminum furniture and boats, frames, etc.

PROCEDURE

Clean the brazing area and remove grease and dirt. Dip the hot end of the rod into **Soudotec F075** flux and coat the joint surface with flux. Heat uniformly using a low carburizing flame. When the flux is fluid, heat the alloy on the joint until it penetrates. Wash out the flux residues with warm water.

MECHANICAL PROPERTIES

Tensile strength: 34 000 psi (235 MPa)

BRAZING PARAMETERS

Diameter:	3.2 mm (1/8")	2.5 mm (3/32")	1.6 mm (1/16")
Bonding temperature:	570°C (1058°F)		
Type of flame:	Slightly carburizing		

Also available in solid MIG wire: **Soudotec EasyMigAlu**

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

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