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ALUMINUM and WHITE METAL

### DESCRIPTION

Bare zinc-aluminum rod for **assembling** and **building up** white metal (zinc alloys) and aluminum and its various alloys.

### CHARACTERISTICS

- No flux required
- Low bonding temperature
- Easy and quick application
- Ideal for repairing aluminum parts
- Excellent for filling in holes in zinc alloys (ex.: «Kirksite»)

### TYPICAL APPLICATIONS

Dies and molds made of «Kirksite», carburator parts, refrigerator handles, alternator parts, electrical saw housings, propellers, aluminum radiators, aluminum boats, engine castings, etc.

### PROCEDURE

**Zinc:** Clean the surface to be welded, chamfer (preferably into a V groove), heat the metal to the point of fusion, tilt the torch and melt the wire into the joint. Fill in the joint. Use flux **Soudotec F078** for thick sections.

**Aluminum:** Clean the surface to be brazed, chamfer (preferably into a Vee groove) and brush the surface with a stainless steel brush to break up the oxide layer before heating. Heat the metal around 500 - 600°F (260 - 315°C), tilt the torch and melt the rod into the joint. Fill in the joint. For a better anchorage, brush the melted deposit under heat to fill up the open pores before filling the joint. Use a stainless steel brush.

### MECHANICAL PROPERTIES

Tensile strength: 50 000 psi (345 MPa)

### BRAZING PARAMETERS

Diameter: 3.2 mm (1/8")  
 Bonding temperature: 370°C (700°F)  
 Type of flame: Slightly carburizing

Rév.: 21\_08

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