

TECHNICAL DATA SHEET 407

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Zn-Al	420	-	-		-	-

Characteristics:

ZINAL 4, Filler wire with composition of Zn-Al (98:2). This wire is adaptable for joining of all solderable grades of Aluminium Alloy. Being low melting alloy. It reduces the possibility of overheating of the parts. It has to be used with **Alunox NCs flux**. This flux being non-corrosive nature, no need of post brazing cleaning. Gives very strong joints. Product does not fume.

Applications:

ZINAL 4 is used for joining aluminium alloys of 1000, 3000 and 6000 series. It can also be used for joining Aluminium to Copper, Aluminium to brass, and Aluminium to stainless steel joints. For dissimilar metal application the long term galvanic corrosion potential should be considered. Also its main usages are in the field of heat-exchangers, air-conditioners and condensers and automotive refrigeration systems

Typical Chemical Compositions (%):

Zn	Al	Si	Fe	Mn	Mg	Cd	Pb	Max. impurities
Rem.	2.00	0.01	<0.01	<0.05	<0.01	<0.01	<0.01	<0.15





Typical Physical Properties:

Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver Gray	377	385	6.90	-	104	-	-

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size (mm)	Type			 OXYACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Cut Length	Coil/ Spool	Preforms				
1.20 - 3.00	√	√	-	√	√	√	√

Customised sizes and other type other than above standard dimensions are solicited case to case basis

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