Technical Data Sheet

AL 822

NOMINAL COMPOSITION

Aluminum	22.0% ± 1.0%
Zinc	Remainder
Other Elements (Each)	0.05% Max
Other Elements (Total)	0.15% Max

PHYSICAL PROPERTIES

Color	Grayish-White
Melting Point (Solidus)	800°F (441°C)
Flow Point (Liquidus)	900°F (482°C)
Brazing Range	900°F - 1000°F (482°C - 537°C)
Specific Gravity	5.25
Density (Lbs/in^3)	0.190
Electrical Conductivity (%IACS) [(1)]	N/A
Electrical Resistivity (Microhm-cm)	N/A

[(1)] IACS = International Annealed Copper Standard

PRODUCT USES

AL 822 is a general purpose aluminum brazing filler metal for joining of all brazeable grades of aluminum and aluminum alloys when using open air heating methods.

PROPERTIES OF BRAZED JOINTS

The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design, metallurgical interaction between the base metal and the filler metal. Joint clearances of 0.003 - 0.005 in. (.076-.127 mm) per side are optimum for achieving highest joint strength. Joints with increased clearances can still produce adequate joint strengths depending on final operating conditions. Zinc based alloys offer the highest strength in comparison to other commercially available low temperature brazing alloys often surpassing shear strengths of 18,000 PSI as long as proper joint design techniques are implemented.

AVAILABLE FORMS

Wire, engineered preforms, specialty preforms per customer specification.

SPECIFICATIONS

AL 822 alloy conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 62-822.

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for AL 822.

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