TECHNICAL INFORMATION SHEET

ALUXCOR® FLUX CORED ZINC/ALUMINUM BRAZING FILLER METAL ZN78, ZN85, ZN98

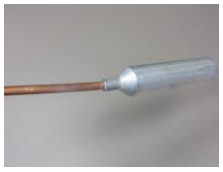
DESCRIPTION:

ALUXCOR® Zinc-aluminum brazing filler metals are designed for low temperature joining of aluminum base metals. Typical aluminum braze alloys melt and flow very close to the base metal melting temperature. The zinc-aluminum group's lower operating temperatures reduce the possibility of overheating the aluminum part.

Joint clearance of 0.003 – 0.005 in., (0.076 – 0.127 mm), is recommended.

Zinc – aluminum alloys are a good choice for joining aluminum alloys of the 1000, 3000, and 6000 series. They can also be used to join aluminum to copper. For dissimilar metal applications the long term galvanic corrosion potential should be considered and a protective joint coating may be required.





NOMINAL CHEMICAL COMPOSITION & TEMPERATURE:

Alloy	Nominal chemistry %	Melting Range °F	Melting Range °C
ZN98	98 Zn , 2 Al	710 - 725	377 - 385
ZN85	85 Zn, 15 Al	715 - 847	379 - 452
ZN78	78 Zn, 22 Al	802 - 898	427- 481

AVAILABLE FORMS & DIAMETERS: (Spools, rings, rod)

0.047" 0.062", 0.078", 0.090"
1.2 mm, 1.6mm, 2.0 mm, 2.3 mm

RECOMMENDED FLUX:

The ALUXCOR® family of zinc/aluminum alloys contain a cesium-fluoroaluminate, (CsAlF), type flux in an internal core. The core percentage and dimensions are calculated to deliver optimum flux release and braze joint protection during heating. Post braze residue from this flux is non-corrosive so removal is typically unnecessary.

SPECIFICATION COMPLIANCE:

Produced to Harris Products Group internal standards.

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES from wire, base materials, and flux can be hazardous to your health.
HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes,* published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER:

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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