

TIG welding and brazing of aluminum and its alloy**GENERAL DESCRIPTION**

The excellent fluidity and the working temperature below the melting point of most Aluminium alloys makes this rod very suitable for brazing with the oxy-acetylene flame on thin sheets and profiles of aluminium.

Penetrates very well in the tightest lap-joints.

Suitable for joining aluminium to copper after tinning the copper with Modi Lastek 3000P.

APPLICATIONS

Aluminium and its alloys (less than 2 % Mg).

Pure Al, AlMn, AlMgMn, AlMg1, AlMgSi1, AlMgSi0.5 (AA1100, 1060, 3003, 3004, 5005, 5050, 6063, 6951 aso...)

Profile constructions, tube joining (lap-joints), window frames, carriage work.

Remark: Anodic oxidation can darken the deposit. When this is not acceptable, use welding rod Modi Lastek 74 (or another one in function of the base metal).

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Si : 10.50 – 13.50	Fe : < 0.55	Cu : < 0.05	Mn : < 0.35	Zn : < 0.10
Ti : < 0.15				

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

GENERAL INFORMATION

Welding positions	NA		
Shielding gas	Argon		
Packing	5 Kg in a cardboard box		
Polarity	AC		
Diameter (mm)	2.0	3.2	4.0
Length (mm)	1000	1000	1000

Tips & Tricks

Clean and de-grease the work pieces and slightly bevel the edges. Apply the flux Modi Lastek 71A (or make a paste with distilled water) and heat the work pieces with a slightly carburizing flame until the flux becomes transparent. Melt the rod along the joint.

Remove flux residues in order to prevent corrosion afterwards (brush it away with hot water or if necessary, plunge it in nitric acid or other appropriate acids followed by rinsing in water).

For normal lap-joints: recommended brazing gap 0.15 - 0.25 mm (0.006 - 0.01inch). For larger lap-joints (> 10 mm (> 0.4 inch)): gap 0.5 mm (0.02 inch).

Furnace brazing: temperature at 600 - 650 °C (1120 - 1200 °F).

Modi Lastek 71 is also suitable for TIG welding of AlSi alloys.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.