

TECHNICAL DATA SHEET 430

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
-Al-Si	590	Al 112	BAISi-4	L-Al Si 12	B Al88 Si 575-585	-

Characteristics:

AL 12 Solid wire of AlSi12 to be used with non-corrosive or corrosive flux. This wire is adaptable for brazing of Aluminium and Low Aluminium alloys. Alloy used with torch, Induction and furnace brazing heat source. This rods to be used with **ALUNOX NC** (Non-Corrosive) or **Flux ODAL**, Corrosive Flux). Give very good capillary action, ductility and penetration with excellent corrosion resistance. Gives very strong joints. For Non-corrosive flux, no need of post brazing cleaning. For Corrosive flux need post brazing cleaning.

Applications:

AL12 can be used for braze piping connections of aluminium and aluminium alloys used for Heat exchangers, Air conditioners, Heat diffuser Discs, Condensers and Automotive refrigeration systems. Brazing of Sandwich bottoms utensils, Heating elements and Radiators. Also used for joining Copper to Aluminium alloy.

Typical Chemical Compositions (%):

Al	Si	Zn	Fe	Mn	Mg	Cd	Pb	Max. impurities
Rem.	12.00	<0.20	<0.80	<0.15	<0.10	<0.01	<0.025	<0.15





Typical Physical Properties:

Colour	Solidus (°C)	Liquidus (°C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Metallic aluminium	575	585	2.65	20%	140	-	-

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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