

FCW ZINAL 4

Flux Cored Wire for Aluminium brazing

TECHNICAL DATA SHEET 413

Specifications:

Alloy	Working Temperature	NF EN ISO 17672	AWS A-5.8	DIN 8513	NF EN ISO	AMS
	(°C)				3677	
Zn-Al	430					

Characteristics:

ZINAL 4 FCW is a Flux Cored Wire of Zn-Al alloy (98:2) with non-corrosive flux at the core of the wire. No External flux required. This wire is adaptable for joining of grades of Aluminium without magnesium. Being low melting alloy, it reduces the possibility of overheating of the parts. Flux being non-corrosive nature, no need of post brazing cleaning.

Applications:

ZINAL 4 FCW is used for joining aluminium alloys of 1000, 3000 and 6000 series (Mg<1%). It can also be used for joining Aluminium to Copper, Aluminium to brass, and Aluminium to stainless steel joints.

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.	2.0	0.01	<0.01	<0.01	<0.01	<0.01	<0.01	<0.1		
Typical Physical Properties:										
Colour	Solidu (°C)	is Lic	quidus (°C)	Density g/cm ³	Elongat %	ion Tensile strength (MPa)	Electrical Conductivi (%IACS)	<u> </u>		
Silver Gre	y 382		407	6.91	75	110-150	-	-		

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)		Туре		000	*	••••	
	Cut Rods	Coil/ Spool	Preforms	OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
1.50 - 3.00	$\sqrt{}$	$\sqrt{}$	$\sqrt{}$				Х

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

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for SELECTRAC. Fumes: Consult information on MSDS, available upon request.

www.selectarc.com

Rev 03/2022