FCW ZINAL 4

Flux Cored Wire for Aluminium brazing

TECHNICAL DATA SHEET 413

Specifications:

Alloy	Working Temperature (˚C)	NF EN ISO 17672	AWS A-5.8	DIN 8513	NF EN ISO 3677	AMS
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

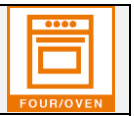
Typical Physical Properties:

Colour	Solidus (˚C)	Liquidus (˚C)	Density g/cm^3	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver Grey	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)	Type						
	Cut Rods	Coil/ Spool	Preforms	OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
1.50 - 3.00	√	√	√	√	√	√	X

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