

# **FCW ZINAL 44**

## Flux Cored Wire for Aluminium brazing

# **TECHNICAL DATA SHEET 412**

#### **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 44 FCW** is a Flux Cored Wire of Zn-Al alloy (78:22) 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 44 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.	22.0	0.01	<0.01	<0.01	<0.01	<0.01	<0.01	<0.15		
Typical Physical Properties:										
Colour	Solidu (°C)	s Lie	quidus (°C)	Density g/cm <sup>3</sup>	Elongat %	tion Tensile strength (MPa)	Electrical Conductivi (%IACS)	•		
Silver Gre	y 420		480	5.8	70	130-180	-	-		

#### **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	V		V				Χ

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

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