



ZINAL 4 TBW

Seamless Flux Cored Soldering Wire
(Joining Cu-Al)

TECHNICAL DATA SHEET 411

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Zn-Al	420					-

Characteristics:

ZINAL 4 TBW Seamless tubular soldering wire of alloy of Zn-Al (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 Aluminum without magnesium Alloy. Being low melting alloy it reduces the possibility of overheating of the parts. Flux being non-corrosive nature, no need of post brazing cleaning. Give very strong joints. No separate flux to apply. No need flux handling systems or corrosive flux to apply. Product does not fume.

Applications:

ZINAL 4 TBW is used for joining aluminum alloys of 1000, 3000 and 6000 series. It can also be used for joining Aluminum to Copper, Aluminum to brass, and Aluminum to stainless steel joints. For dissimilar metal applications the long-term galvanic corrosion potential should be considered. Also, its 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.	2.00	0.010	<0.010	<0.010	<0.01	<0.010	<0.010	<0.15





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	385	420	6.90	-	104	30	-

Properties of Brazed Joint:

The properties of a brazed joint depend 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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