



TECHNICAL INFORMATION SHEET

COR-AL FLUX CORED ALUMINUM TORCH ALLOY

NOMINAL CHEMICAL COMPOSITION:

Aluminum	BALANCE
Titanium	0.20 % max.
Silicon	6.0% max
Beryllium	0.0003 max
Others Each	0.05% max.
Iron	0.80% max.
Total	0.15 % max.

TYPICAL PHYSICAL PROPERTIES:

Solidus	1065°F (574°C)
Liquidus	1170°F (632°C)

DESCRIPTION:

COR-AL is a tubular aluminum flux cored rod with a precisely calibrated ratio of active flux to assure versatile performance. It can be used for oxy-fuel brazing of aluminum base metal and the flux core eliminates the need for a separate flux application. The surface should be ground and beveled along with being clean, free of dirt, grease and oxides. Use a slightly carburizing flame with brazing technique 1" to 3" from the surface.

Deposit small amounts of the alloy and allow it to flow out on the work area. For built up work, reduce the heat and play the flame on the filler rod just above the work area and melt drops from filler rod into the work piece. Crimp the ends of rods after use to seal in the unused flux.

AVAILABLE FORMS

1/8" (3.2mm) & 3/16" (4.8mm) rods

RECOMMENDED FLUX:

Separate flux is generally not required with COR-AL, but Harris Al-braze Flux may be applied as a supplement to improve flow. Remove flux residue with warm water and a stainless steel brush.

SPECIFICATION COMPLIANCE:

Harris Internal

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER:

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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