



TECHNICAL INFORMATION SHEET

ALUXCOR® 95/5 ZINC-ALUMINUM PASTE

CHEMICAL COMPOSITION (metal content – single values are maximum), %:

Al	4.50 – 5.50
Fe	0.05
Mn	0.05
Pb	0.05
Si	0.05
Mg	0.05
Cd	0.01
Sn	0.05
Bi	0.05
Cu	0.05
Zn	Remainder

PHYSICAL PROPERTIES:

Melting point - 720°F (382°C)

Viscosity: 32 – 50 TD spindle

5 rpm

Powder Mesh 60 (US Standard Sieve)

Powder content %: Nominal 62 – 67

SOLDERING PROPERTIES:

Aluxcor 95/5 solder paste is a powder form of solder alloy mixed in a custom flux/binder to form a paste. The paste is applied to the part prior to brazing. During heating the binder burns off and the filler metal powder melts when soldering temperature is reached. This product is primarily used in automated or semi-automated soldering applications.

Aluxcor 95/5 is fluid at brazing temperature and best results occur with clearances of 0.001" – 0.003", (0.03 mm – 0.08 mm).

RECOMMENDED APPLICATIONS:

Aluxcor 95/5 paste is designed to join aluminum to aluminum. In some cases it can be used to solder aluminum to copper but completed joints may be subject to in service galvanic corrosion if not properly protected. The low operating temperature reduces the likelihood of base metal melting which is an issue with higher temperature aluminum brazing filler metals.

FLUX REMOVAL:

Flux residue is considered non-corrosive. As with all noncorrosive fluxes, users should check service conditions to verify the environment won't change the chemical composition of the noncorrosive residue, (i.e. humid acid environments might chemically react with the noncorrosive residue making it corrosive). Residue should develop a hard white inert residue in most environments without issues.

STORAGE AND HANDLING:

Store in a cool dry environment. Recommended storage temperature range is between 60 - 70°F. Avoid extreme heat and cold and do not allow product to freeze. Keep the container tightly sealed to prevent drying or moisture pick up when not in use. Replace syringe tips and use Teflon® tape to seal containers or packages. Stir product in containers with a spatula prior to loading in dispensers. This will ensure even mixture of powder and binder. Use caution to minimize air entrapment.

When correctly stored, shelf life of jars, pails, and drums is typically least six months. Syringe and cartridge shelf life is approximately three months.

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, Safety Data Sheets, (SDS), 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 NW 36 Street, #130, Miami, Florida 33166-6672; 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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