



TECHNICAL INFORMATION SHEET

Al-Braze®1070 BRAZING FILLER METAL Wire, Rod, & Al-Braze® 1070 KIT

DESCRIPTION:

Al-Braze 1070 is an aluminum-silicon brazing filler metal designed for flame brazing aluminum to aluminum. It is formulated to melt below the melting point of brazeable aluminum base metals and its narrow melting range provides rapid flow into the capillary.

Aluminum does not change color when heated and Al-Braze 1070 wire melts at a temperature close to the aluminum base metal melting point. For this reason care should be used during heating and the base metal should be heated to brazing temperature before filler metal application. Flux should be applied to the part prior to heating. Flux will liquefy and turn "clear" close to brazing temperature and this can be a useful indicator for when to apply the 1070 wire.

NOMINAL WIRE CHEMICAL COMPOSITION %:

Si	12.0
Al	Remainder

PHYSICAL PROPERTIES, (Al-Braze wire)

Solidus 1070°F (577°C)
Liquidus 1080°F (582°C)
Brazing Range 1080°F- 1120°F (582°C - 605°C)

AVAILABLE FORMS:

Bare wire & rod - in standard diameters.

Kits – 1/6" diameter wire with 1/3 oz. Al-braze EC brazing flux



SPECIFICATION COMPLIANCE:

Al-braze 1070 wire – AWS A5.8 Classification BAISI-4
ISO 17672 Al 112

Flux – Conforms to Harris Products Group engineering standard

FLUX DATA:

Al-Braze 1070 is used with Al-Braze EC flux. The flux is a powder and can be mixed with water to form a paste. Use a brush to apply paste flux to the assembly. It also can be sprinkled on the part. With this approach heat indirectly until flux liquefies. An alternate method is to heat the wire end with the flame and dip it into the flux powder. The flux will adhere to the heated wire and the flame can be used to melt flux from the wire onto the part.

Flux is hygroscopic and will absorb moisture. Keep container tightly closed.

Remove all flux residues after brazing.

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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