

## HABCO AL 445

### UNIQUE ACTIVE FLUX-CORED TORCH ALLOY FOR BUILD-UPS ON ALUMINUM

#### FEATURES

Due to the self-contained flux, **HABCO AL 445** is extremely easy to use. Deposits are high strength, have excellent plasticity and provide a perfect color match (turns gray if anodized). **HABCO AL 445** can be used in any position and deposits are easily shaped and readily machinable.

#### APPLICATIONS

**HABCO AL 445** was designed for repairing cracks and breaks in aluminum casts or extrusions. Building up of worn or broken parts. Model work, mold/die changes, or fabrication of cast, sheet and wrought aluminum. Ideal for farm irrigation pipes.

#### INSTRUCTIONS

Clean work surface thoroughly. Remove any dirt, surface corrosion, grease etc. Sand lightly if possible – joint gap should not exceed 1/8" (3.25mm). Adjust torch to a slightly carburizing flame and apply heat to work/joint area, keeping torch tip 1" to 2" (25mm to 50mm) from surface. Melt a small amount of **HABCO AL 445** onto work piece at the start of the joint and continue heating (moving flame along the joint) until the deposit starts to flow out- then continue adding alloy as you would any brazing or welding filler metal. Brushing under hot water will remove flux residue.

**Tensile Strength: 34,000 Psi (24 kg/mm<sup>2</sup>)**

**Liquidus: 1100°F (598°C)**

**Elongation: approx. 15-25%**

**Corrosion Resistance: Good**

**Hardness: 40-55 HB**

**Diameters:** (in) 1/8  
(mm) 3.25