

HABCO AL 446

LOW TEMPERATURE SOLDER FOR ALUMINUM AND DISSIMILAR METALS

FEATURES

- High Strength
- Low Working Temperature
- Can be used with: Torch, Iron, Furnace, Induction
- Will wet on anodized surfaces; use **HABCO FX 840 Flux**
- REAL Money-Saver enables repair/salvaging of parts which would otherwise be scrapped.
- Easier to use than similar competitive products and has wider range of applications.

APPLICATIONS

- Soldering Aluminum
- Aluminum to other metals
- Instrument Housings and Parts
- Refrigeration and Air Conditioning
- Repair Light, White Metal Tubing (except white metals)
- Carburetor Bodies
- Zinc-Base Castings
- Copper to Aluminum Tubing

INSTRUCTIONS

Clean work surface thoroughly. Remove dirt, rust, grease and surface corrosion. Joint gap should be limited to a maximum of .005" for best results. Apply **HABCO AI 329 Flux** evenly to all joint surfaces. Adjust torch to a low slightly carburizing flame and apply heat broadly or indirectly, if possible, **avoid putting flame directly into the flux**. Always keep torch in motion over work piece. Apply **HABCO FX 840 Solder** when Flux begins to bubble and continue to add solder as required until joint is complete. Flux residue can be removed by rinsing in hot water - 150°F (65°C). USE ONLY **HABCO FX 840 FLUX**.

Tensile Strength: 22,000 Psi (15 kg/mm²)

Liquidus: 450°F (232°C)

Diameters: (in) 1/16 1/32 1/8
(mm) 1.6 2.5 3.25