



## TBW Zinal 4

### ZINC - ALUMINUM

#### DESCRIPTION

**Zinc-aluminum extruded tubular flux-cored rod** containing a non corrosive flux for low temperature soldering of aluminum and its various alloys, aluminum with copper and aluminum with stainless steel.

#### CHARACTERISTICS

- No other flux required
- Low bonding temperature
- Easy and quick application
- Less risk of deforming the base metal
- No post-braze cleaning required
- High fluidity and good wettability

#### TYPICAL APPLICATIONS

Dissimilar assemblies. Heat exchangers, refrigeration and brazing of air-conditioning systems, aluminum condensers, radiators, aluminum pipe fittings, etc. **Not made for aluminum-magnesium alloy.**

#### PROCEDURE

Clean the surface to be brazed removing all grease, oil and dirt. Heat the parts up to 460°C (860°F) and melt the rod into the joint. Fill in the joint and keep the flame slightly away from the base metal.

#### BRAZING PARAMETERS

Diameter:	3.2 mm (1/8")	1.6 mm (1/16")	1.2 mm (.045")
Bonding temperature:	440 - 460°C (824 - 860°F)		
Type of flame:	Slightly carburizing		

Rév.: 21\_08

*Specialized welding alloys and technology. For technical assistance or for ordering :*

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