Fontargen A 407 L

Aluminum hard solder

Classifications			
DIN EN ISO 17672	DIN EN 1044	DIN 8513	DIN EN ISO 3677
Al 112	AL 104	L-AlSi12	B-Al88Si-575/585
AWS A 5.8	Material no.		
BAlSi-4	3.2285		

Composition, typical analysis (% w/w):							
Al	Si						
88.00	12.00						

Technical specifications			
Working temperature	590 °C	Specific weight	2.7 g/cm³
Melting range	575 - 585 °C	Tensile strength	100 N/mm²

Characteristics/application

Good capillary action. For structure and color matching on aluminum and rolled/cast aluminum alloys. The Mg content must be ≤ 3%. The solidus temperature should be > 630 °C. Not suitable for joints that are to be anodized. This brazing alloy is also suitable for joining aluminum with Cr-Ni steel.

Heat sources

Inert gas furnace, vacuum furnace, induction and resistance heating, acetylene torch

Brazing fluxes

F 400 series

All provided information is based on careful investigation and comprehensive research.
Nevertheless, we do not assume any warranty and liability for the correctness of the information or changes.

Fontargen A 202 M

Copper-silicon wire electrode for MIG brazing

Classifications			
DIN EN ISO 24373	DIN 1733	AWS A 5.7	
S Cu 6560 (CuSi3Mn1)	SG-CuSi3	ERCuSi-A	
Material no.			
2.1461			

Typical analysis of the weld metal (% w/w)							
Cu	Fe	Mn	Si	Sn	Zn		
Remainder	0.20	1.20	2.90	0.10	0.10		

Mechanical properties of pure welding deposit in accordance with DIN EN 1597-1 (minimum values at room temperature)			
Melting range	965 - 1032 °C	Impact energy	60 J
Tensile strength	350 N/mm²	Thermal conductivity	35 W/m • K
Yield strength	120 N/mm²	Electrical conductivity (20°C)	3 - 4 Sm/mm²
Elongation (l=5d)	40%	Thermal expansion coefficient	18.1 • 10^{-6}/K
Hardness (Brinell)	80 HB	Specific weight	8.5 kg/dm³

Characteristics/application

MIG brazing of zinc or aluminum-plated and uncoated steel plates. Applications: car body, air conditioning, ventilation, and container construction. The corrosion resistance of zinc-plated surfaces remains unaffected in the joining area.
Very little deformation when brazing thin steel sheets.

Heat sources	Protective gas (DIN EN 439)
MIG/MAGM/laser brazing	I 1 (Argon) M 12 (Argon + 2.5% CO_2) M 13 (Argon + 1 - 3% O_2)

Current mode	Delivery form
DC (positive terminal)	Diameter (mm): 0.8/1.0/1.2/1.6

Spool type	Approvals
B300 (Basket coil), S200, S300 (Mandrel), Barrel coil, Additional delivery forms on request	TÜV

Welding position, in accordance with DIN EN 287							
PA	PB	PC	PD	PE	PF	PG	
x	x	x		x	x		

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