

18 S.W.G.

ALU-SOL

MULTICORE SOLDER FOR SOLDERING ALUMINIUM

CONTAINS 4 CORES OF FLUX

NO extra flux required

NO precleaning of normally oxidised surfaces needed

NON-CORROSIVE flux residue

Made in England by

MULTICORE SOLDERS LIMITED

HEMEL HEMPSTEAD, HERTS HP2 7EP.

Telephone: 0442-3636 Telex: 82363

DIRECTIONS FOR USE:

The techniques and equipment for using ALU-SOL are basically similar to those used for soldering other metals but due to the high specific heat of an aluminium workpiece it is necessary to use a heat source of larger heat capacity (not higher temperature) than usual. Do not overheat or flux will char.

The correct soldering temperature range is 280-370°C (536-700°F). Best method is to heat the workpiece surface and to hold the end of the cored solder against the surface until it is seen to melt and flow, i.e. melt the solder indirectly by heating the joint area adjacent to the point of application of the solder. Avoid direct application of soldering iron or gas flame to the solder.

Flux residue after soldering is non-corrosive and non-conductive but if desired it may be removed in seconds with water.

Maintain storage temperature between 0-35°C (32-95°F).

To provide maximum protection against subsequent electrolytic corrosion in humid atmospheres, joints should be painted with a protective coating or sealed.

Although the fumes from ALU-SOL are believed to be harmless, they are pungent and good ventilation or forced-air extraction should be provided in the working area.

Ask for detailed technical leaflet.

NOTE:

As aluminium can be subject to a greater degree of oxidation and electrochemical corrosion than most other metals, customers are recommended to undertake their own research to determine whether joints made with ALU-SOL are satisfactory for the products soldered which may be subject to different climatic conditions.

Thus, whilst Multicore Solders Limited believe that ALU-SOL may provide good soldering of aluminium and aluminium alloys, it is emphasised that the use of this solder is entirely the responsibility of the user. The solder will be replaced without charge if found defective in manufacture. Subject to this, all warranties or conditions, statutory or otherwise, and responsibility for any loss or damage however caused, are excluded.

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