



WELCO 52

FLUXES

ZINC ALLOY FOR POT METAL AND ALUMINUM

A PREMIUM VIRGIN METAL ALLOY FOR TORCH OR GTAW (TIG) WELDING

Applications: WELCO 52 is used extensively on aluminum, zinc base metals and galvanized metal. It is excellent for Kirksite dies, grills, gutters, outboard motor castings, carburetors, appliances and automotive hardware.

Procedure: For zinc die cast, remove all dirt, scale, oxide and plating from the joint area. Bevel thicker sections. On thin sections use a "back-up" plate. Preheat to about 400°F and sprinkle **WELCO 52 FLUX** in the joint. Use a neutral flame and incline the torch in the direction of travel. Heat until the flux liquefies, then add the alloy drop-by-drop and flow out. For aluminum, no flux is needed but use a stainless steel wire brush to clean the aluminum, and rub the rod on the heated part until the alloy melts and flows. Remove the flux residue with warm water. For TIG welding, use argon gas and AC High Frequency.

Sizes Part No. 52-18
1/8" (3.2 mm) x - 18" (450 mm). **\$16.59 LB**

Features: Melting Point - 732°F
Color match - Excellent
Self-fluxing on aluminum

**CAN ALSO
BE USED ON
ZINC
(POT METAL)**



UNI-4200: This is a self fluxing alloy for joining aluminum to aluminum.

TEST KIT W/ 6 STICKS

#UNI-4200

\$9.35 EA STICK LENGTH 8 1/2"

WELCO 120 Aluminum

PREMIUM QUALITY, BEAD FORMING TORCH ALLOY

Applications: Deposits of WELCO 120 solidify rapidly. This makes it well suited to applications where a filling, bead forming deposit is necessary.

Procedure: The joint area should be clean, free of dirt, grease and oxides. Use WELCO NO. 10 FLUX for best results. Surfaces should be ground and beveled. Use an excess acetylene flame and brazing technique. Flux residue is easily removed with a warm water rinse.

Sizes: 1/16" (1.6 mm) x 18" (457 mm). **#W120-116 \$16.99 lb**
3/32" (2.4 mm) x 18" (457 mm). **#W120-332 \$16.99 lb**
1/8" (3.2 mm) x 18" (457 mm). **#W120-18 \$16.99 lb**

Features:

Tensile strength - Up to 30,000 psi
Solidus - 1055°F Liquidus - 1155°F
Good color match and corrosion resistance

**WELD/BRAZE THE BOTTOM OF AN
EMPTY SODA CAN WITH YOUR TORCH**

FLUX SOLDER 1/16" X 10' W/ 1oz KIT

JOIN ALUMINUM TO COPPER

UNI-4300

A superior alloy for soft soldering aluminum. Very low melting point with a high tensile strength. Ideal for repairing tubing, refrigerant coils, joining aluminum to aluminum and copper to aluminum.

**UNI-4300
ALUMINUM SOFT SOLDER
KIT
\$16.95 EA**

- STRONG LOW TEMPERATURE
- GOOD CORROSION RESISTANCE STRONGER THAN ORDINARY SOFT SOLDER
- GOOD STRENGTH EVEN AT HIGHER TEMPERATURE
- EXCELLENT WETTING AND FLOW CHARACTERISTICS

UNIWELD ALLOYS division of UNIWELD PRODUCTS, INC.

USA FLUXCORED ALUMINUM

1/8" X 32" Lengths

APPLICATIONS

An all-position, oxyacetylene welding or brazing rod used in repairing broken or cracked aluminum extrusions or castings. Typical applications would include building-up machinable deposits or worn or broken parts, model work, mold/die changes and thin sheet metal.

PROCEDURES

Remove any plating, dirt, grease or surface corrosion from the area to be welded or brazed. Sand and clean the weld area thoroughly. The gap to be welded should not exceed 1/8". Bevel heavy sections to form a 60° to 75° V-notch. Using a slightly carburizing flame, heat the work area by keeping the flame 1" to 2" from the weld area. Continue to heat the weld area while occasionally touching the fluxcored aluminum rod to this area under the torch flame. Do this until small amounts of alloy are deposited and the filler metal starts to flow through the gap of the heated weld area. Be sure that each drop of filler metal flows out and bonds to the base metal, but do not melt the base metal. Allow the welded part to cool and wash away the flux residue with warm water and a stiff brush.

CHARACTERISTICS

USA Fluxcored Aluminum is one of the most versatile torch rods. The self-contained flux offers protection from handling and moisture. A broad operating temperature range and excellent color match makes this alloy suitable for many applications. It offers good plasticity, high strength and is readily machinable.

SPECIFICATIONS

Liquidus 1100°F
Tensile Strength..... 32,000 psi
Color Match Good (not to be anodized)
Sizes 1/8 x 32 inch cut length

**#AFC-18
\$18.50 LB**