ARCTEC® AS 406 ALUMINUM

a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® AS 406 is a bare brazing alloy designed for brazing of zinc base material such as zinc die castings, white metal and pot metal. This alloy produces strong, dense and porosity free welds. May also be used for brazing aluminum alloys. Can also be applied using T.I.G. (GTAW) equipment.

APPLICATIONS:

ARCTEC® AS 406 is recommended for torch brazing white metal, zinc die castings, pot metal and other zinc based metals. Also suitable for brazing aluminum alloys and galvanized material without the use of a flux. Used for repair of die castings, aluminum boat propellers, aluminum radiators, power tool and power mower housings.

WELDING PROCEDURE:

Remove surface oxides and clean the weld zone free of all contaminants by applying heat with a torch and brushing with a stainless steel brush. Bevel sections to a 90^{o} included angle. Heat metal until it starts to flow and then maintain temperature by angling the torch flame parallel to the surface and subsequently heat and apply the filler material. Use filler rod to break down resistance of the skin on the weld puddle to achieve proper flow characteristics. Repeat procedure until the weld joint is completely filled. Thorough tinning of both surfaces, before joining, produces best results. For T.I.G. applications use the same procedures employed when welding aluminum.

MECHANICAL PROPERTIES:

Hardness	Tensile Strength	Elongation
83 HB	47,300psi (326Mpa)	8% - 2"

OPERATING PARAMETERS:

WELDING PROCESS: OFW-TB

Use slightly carburizing flame.

Melting Point: 732^{o}F (333^{o}C)

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