CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO L-Al 99 F

International standards

Material No.	
EN 1044	
DIN 1732	

Approvals ---

Typical applications and characteristics

CARBO L-Al 99 F is a flux cored brazing rod for brazing of aluminium and its alloys.
It is applied for repair-jobs on engines and gear-boxes.
The product is very economical as there is no need of shielding gases. The exact ratio of incorporated flux guarantees easy flowing because all oxides from the surface of the base material are removed.
There is no need of preparation on the base material's surface.
The structure of the deposit is very homogenous and free of porosity especially in the diluted capillary section.

Soldering instruction.

The flame adjustment depends on the thickness of the base material
After brazing flux-residues should be removed and the open end of the applied rod must be closed by hammering for avoiding uncontrolled reactions of out coming flux.

Operating temperature ---

Base materials

3.2381 G-AlSi10Mg
3.2383 G-AlSi10Mg(Cu)
3.2581 G-AlSi12
3.2583 G-AlSi12(Cu)

Aluminium, Silumin, Silafont, Alufont, Alpax, Aluman, Peraluman, Duraluminium, Aldrey.

Mechanical properties of all-weld metal

(typical values**)**

Tensile strength R_m N/mm	**Hardness** HB 10	**Elongation A_5 %**	**Working** Temp: °C
110	approx. 42	18	610-640° C

Weld metal analysis (typical, wt. %)

Al	Si	Fe	Cu	Mn	Mg	Zn	Ti
Basis	0,25	0,4	0,05	0,03	0,03	0,07	0,03

Dia. / Length	Pcs. / packet	Pcs. / carton	kg / 1000	kg / packet	kg / carton
2,0 x 500	167	667	30,0	5,0	20,0
3,0 x 500	118	472	50,8	6,0	24,0
4,0 x 500	78	312	77,0	6,0	24,0

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