

ARCTEC® 402 ALUMINUM



GENERAL CHARACTERISTICS:

ARCTEC® 402 is a thin flowing, low melting aluminum brazing alloy for use on all weldable grades of aluminum. Has good capillary action with thin flowing smooth deposits that have good color match with the base metal.

APPLICATIONS:

ARCTEC® 402 is used for brazing of all weldable grades of aluminum. Used for maintenance, production and repair to furniture, window frames, radio equipment, aluminum appliances, refrigeration and all forms of extruded aluminum profiles.

WELDING PROCEDURE:

Clean the weld zone free from dirt, grease and oxides. Allow joint clearances of .005" to .010". Use 3x carburizing flame. Keep torch in constant motion while heating weld area in order to avoid melt through. Dip heated end of rod in Arctec # 71 Flux and transfer to joint area. Continue heating until flux liquefies and then melt a drop of alloy from the rod. Continue this process until the joint is filled. After completion of the weld allow to cool slowly, then rinse the excess flux off using warm water and a stiff brush.

MECHANICAL PROPERTIES:

Tensile Strength Up to 34,000 psi (234 Mpa)

OPERATING PARAMETERS:

WELDING PROCESS: OFW-TB

Melting Point: 1075°F (580°C)

Available diameters:	Inch.	1/16"	3/32"	1/8"
	mm.	1.60	2.50	3.25

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