



TEXAS * PENNSYLVANIA * NORTH CAROLINA
<http://hi-alloy.com>

HI-ALLOY 155

FLUXLESS ALUMINUM REPAIR ALLOY

DESCRIPTION: Hi-Alloy 155 was designed to provide a way to make low temperature repairs on thin gauge aluminum without the use of a flux. With a little practice you will be able to easily fabricate or make repairs on aluminum castings, sheet, or thin plate. You may also use this product to make repairs to zinc castings and items made of white or pot metals.

TYPICAL APPLICATIONS: Fabrication and repair of aluminum window screen frames, gutters, siding, pontoons, irrigation pipe, condensers, canoes, and sealing leaks in aluminum fishing boats. Repair of zinc based castings found in chainsaws, motorcycles, lawn mowers, and outboard motors.

PROCEDURES: Remove contaminants from work piece using a clean stainless steel brush, adjust oxy-acetylene torch to a neutral flame or use a hand held propane torch, heat the work area broadly to about 700° F and rub the 155 alloy on the area to be repaired, (do not put the flame directly on the rod,) continue to heat the base metal until the 155 alloy is able to penetrate the oxide film, the alloy will melt and flow under the oxide, continue heating and adding alloy until the repair is complete. Joining may be accomplished with T- joints, butt joints, and lap joints. Best results are attained when the parts to be joined are tinned independently. Parts thicker than 1/8" should be beveled. Use jigs and clamps to secure the work pieces if necessary. Allow finished part to cool slowly in still air.

AVAILABLE SIZE: 1/8 X 18"

MELTING TEMPERATURE: 720° F

TENSILE STRENGTH: Up to 39,800 psi