



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

## HI-ALLOY FLUXKORED

### ALUMINUM BRAZING ALLOY

**DESCRIPTION:** Hi-Alloy Fluxkored is a tubular filler rod with a highly active flux inside. Being inside the rod, the flux is protected from contamination and is released in the appropriate amount as the rod is melted. This alloy can be applied in all positions with an oxy-acetylene torch and can be used for either buildup or joining. Deposit will darken if anodized.

**TYPICAL APPLICATIONS:** Repair, buildup, and fabrication of all weldable grades of aluminum sheet, plate, and castings.

**PROCEDURES:** Carefully clean or grind off surface oxides and other contaminants. Heavier parts should be beveled to a 60° Vee. Adjust torch to a slightly carburizing flame. Preheat part to 1000° F then melt off a small amount of Fluxkored rod and allow it to drop onto the part. Continue heating until the flux turns clear and the drop begins to flow. Maintain working temperature and apply small amounts of Fluxkored as needed to complete your procedure. Reduce heat to build up, adds Hi-Alloy 129 Flux to increase capillary action if desired. Remove flux while warm by immersing the part in hot running or agitated water; use a stiff brush to remove stubborn residues.

**SIZE AVAILABLE:** 1/8 X 32" in 2 lb Tubes

**MELTING TEMPERATURE:** 1100° F

**TENSILE STRENGTH:** Up to 32,000 psi