



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

HI-ALLOY SIL-SUPER

LOW TEMPERATURE ALUMINUM SOLDER

DESCRIPTION: Sil-Super Solder is one of the few alloys that will join aluminum to dissimilar metals such as copper, brass, bronze, steel, and nickel alloys. It will also join any of these alloys to each other providing a joint stronger and more corrosion resistant than typical lead solders. Sil-Super can be used to repair zinc die cast parts, but is not recommended for use on magnesium.

TYPICAL APPLICATIONS: Refrigeration and A/C units, radiator repair, instruments, repairing, filling, and sealing of aluminum sheets and castings.

PROCEDURES: Carefully clean joint area of contaminants, prepare a tight fitting joint, apply Hi-Alloy Sil-Super Flux, adjust torch to a soft carburizing flame, heat the parts indirectly if possible or play the flame back and forth being careful not to char the flux, (when the flux begins to bubble you are nearing the solder melting temperature,) continue heating and touch the solder to the joint, as the solder melts and flows continue to apply until the joint is filled. The solder can also be cut and positioned prior to heating. Remove flux residues while still warm by immersing part in hot running or agitated water. Use a stiff brush to remove stubborn residues.

CAUTION: This alloy CONTAINS CADMIUM. Do not use on lines for drinking water, in food service, or medical applications. Flux produces pungent odors, use only in well ventilated areas.

AVAILABLE SIZES: 1/16 3/32 1/8 All in 1/lb Spools

1/16 Available in a 2 oz Kit Containing 10' of Solder and ½ oz. of Flux

MELTING TEMPERATURE: 509° F

TENSILE STRENGTH: Up to 20,000 psi on Aluminum to Copper.
 Up to 30,000 psi on Aluminum to Aluminum.

Sil-Super Flux Available in ¼ lb Bottles.