

MF-50

ALUMINUM BRAZING ALLOY MF-50



Easy to use – without base metal sagging or wrinkling.
Brazing Alloy for all types of Aluminum.
Fluxed Residue washes off easily with warm water.

SPECIAL FEATURES

- MF 50C Can build (bead form) or thin flow due to the specially designed flux cored.
- MF 50C Gives goods high tensile strength
- MF 50C Can apply at a lower temperature than base metal melting point.
- MF 50C Provides perfect colour match.
- MF 50C Flux residue washes off easily with warm water .



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OUTSTANDING PROPERTIES:

- MF 50C Is a superior alloy for that :
- Can be applied at lower temperature than base metal melting point to prevent collapsing of work piece.
- Gives extremely high tensile strength.
- Provides perfect color match, with good corrosion resistance.
- Can be applied in all positions, Depending of job Design

APPLICATIONS

- Repairing all brazable aluminum castings – filling in holes, building up worn or missing sections and joining cast to wrought parts.
- General purpose outdoor use on repairing aluminum skids, platforms, loading docks, truck bodies, irrigation piping, fences and railings.
- Joining thick to thin sections requiring a combination of braze-welding and brazing techniques.

MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	up to 35,000 PSI (250 MPa)
Bonding Temperature	800 - 1000°F

BRAZING TECHNIQUES:

Brazing Techniques: Clean the surface and preheat heavy sections. Adjust the torch to a neutral to slightly carburizing mixture. Once piece is preheated simply allow a small amount to melt off the rod. When the flux flows out apply the alloy drop by drop, moving the torch constantly. Allow to cool and thoroughly remove all flux residues by scrubbing in warm water.

For thin flowing, adjust the torch to 3X carburizing and preheat to a higher temperature. Then touch the end of the rod to the work and continue heating, forcing the molten flux through the joint. Allow the rod to melt off and flow through the fluxed area. Keep the torch moving constantly.

