

MF - 51

MF-51 LOW TEMPERATURE SOLDER FOR JOINING ALUMINUM TO OTHER NON FERROUS AND FERROUS METAL



DISSIMILAR JOINING OF PURE COPPER TO ALUMINUM ALLOY

- Excellent wetting and flow characteristics on almost all ferrous and non-ferrous metals.
- Retains high strength even at temperatures up to 350°F (175°C)
- Better corrosion resistance and higher strength than ordinary soft solders.



MF-51

SPECIAL FEATURES

- MF-51 Excellent for Low Temperature Joints on
- Aluminum tube, copper tube, and refrigeration and air conditioning units
- Aluminum radiators
- Repairs to instruments
- Joining of dissimilar metals, Aluminum, Copper, Bronze and Steel
- Can also be used on anodized aluminum

TYPICAL MECHANICAL PROPERTIES

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|-------------------------------|-----------------------------|
| ● Undiluted Weld Metal | Maximum Value Up to: |
| ● Tensile Strength | up to 20,000 PSI (145 Mpa) |
| ● Electrical Conductivity | Good |
| ● Corrosion Resistance | Good |
| ● Colour Match | Very Good on Aluminum |

Soldering Instructions

Soldering Techniques: Joint area should be thoroughly cleaned. Best results are obtained when maintaining a joint clearance of not more than .006". The entire joint area should be completely covered with MF-51 Flux. Heat part indirectly with a soft flame being careful not to burn the flux. As soon as flux starts to bubble, dip solder into flux. and transfer it to joint. Continue heating until solder flows through the entire joint. Allow to cool slowly. Flux residue can be removed with hot water and stiff brush.

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