



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 67 – Convenient all in one, easy to use aluminium brazing alloy

FEATURES & APPLICATIONS

Ideal for joining aluminium extrusions used in the manufacture and repair of aluminium doors and windows. Also for repairing leaders, gutters, siding, aluminium boats and instrument boxes. Most kirksite and zinc base die castings can be repaired with this alloy. Can also be used as a wearfacing alloy on aluminium.

Maximum strength, self-fluxing solder for joining, build-up and hardfacing aluminium.

- High zinc content gives good colour match to aluminium.
- No flux required - post clean-up is eliminated.
- Low working temperature prevents warpage, distortion and discolouration.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Zn	Cu	Al
Bal	9	10

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength	102,000 PSI (700 MPa)
Working Temperature	approx. 710°F (375°C)
Corrosion Resistance	Very Good
Colour Match	Very Good

SOLDERING INSTRUCTIONS

Soldering Techniques: Joint area should be thoroughly cleaned, preferably by mechanical means (scraping, filing, etc). Bevel heavy sections. Use jigs or clamps to hold parts in alignment. With a carburising flame, heat base metal to approximately 750°F (400°C), rub alloy in the joint. Do not heat rod with flame but let the heat from the part to be soldered melt the rod. Vigorous rubbing of the base metal surface allows the rod to break through the tough oxide and bond to the sound metal. Higher strengths and better bonds may be obtained by using a clean stainless steel wire brush through the molten solder to the base metal surface. Allow part to cool slowly.

PROLINE
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