

Lastek 3476 IS

Soft solder for aluminium

CLASSIFICATION

GENERAL DESCRIPTION

Flux cored soft solder for aluminium and its alloys: pure aluminium, AlMg up to 3 % Mg, AlMn, AlCu. Contains no zinc or cadmium, provides good penetration and has a good electrolytic corrosion resistance on aluminium. The low working temperature avoids distortion of profiles and plates.

APPLICATIONS

Soldering of most Aluminium alloys, but AlMg5, AlSi12 and anodised aluminium are very difficult to wet. Lastek 3476IS can also be used for joining aluminium to copper, brass, nickel silver, stainless steel and so on.

Temperature: 178 - 270 °C (350 - 520 °F).

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Sn : 15.00 - 20.00	Ag : 1.50 - 2.50	Pb : Balance		
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MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 38 MPa		

GENERAL INFORMATION

Welding positions	NA		
Shielding gas	NA		
Packing	0.5 kg spool		
Polarity	NA		
Diameter (mm)	1.6	2.0	3.0

Tips & tricks

- Clean and degrease the pieces to be joined.
- Preheat the workpieces rapidly up to a maximum of 350 °C (662 °F) with an oxy/acetylene, propane or butane flame (or use a soldering iron with copper tips), and apply the solder.
- Do not overheat the flux (max. temperature 350 °C - 662 °F).
- For an optimum strength, use sufficient overlapping and use a joint clearance of 0.05 - 0.10 mm (2-4 thou).

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.