

MG 420

**Flux-cored aluminum brazing rod
for dirty applications**



GENERAL CHARACTERISTICS:

Unique aluminum torch alloy with the highly active flux contained inside the rod where it is protected from contamination. It can be applied in all positions with the oxy/fuel torch. Tungsten inert gas, DC welding machines and other expensive welding equipment are not needed for the repair of most aluminum parts; therefore this rod fills the needs of many welders both in the shop and field.

APPLICATIONS:

Fabricating, build-up and repair of all weldable grades of aluminum including cast alloys. Ideal for joining dissimilar gauges and for poor fit-up applications where a less fluid alloy is desired.

TECHNICAL DATA:

Typical Tensile Strength	Up to 34,000 psi (234 N/mm ²)
Working Temperature	1100°F (598°C)
Elongation	15-25%
Corrosion Resistance	Good
Hardness	40-55 HB
Color Match	Good (will darken if anodized)

Diameters Available	1/8" (3.2mm)
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PROCEDURE:

Remove oxides and foreign material from weld area preferably by mechanical means (scraping, filing, etc.). Bevel parts thicker than 3/16" (5.0 mm) to form a 60° vee. If extra flux is needed use MG 410F flux. With the oxy/fuel torch adjusted to a slightly carburizing flame, heat work broadly to about 1000°F (538°C). Melt 1/4" (6 mm) of the rod off onto the workpiece (the flux will also turn to a liquid); continue heating until alloy flows out. Lower the angle of the torch; continue adding alloy a drop at a time until weld is complete. Allow part to cool slowly. Remove all flux residue with stiff brush and hot water.