

MG 460



Low temperature solder for joining aluminum to itself or other metals

GENERAL CHARACTERISTICS:

A special complex alloy system solder that has excellent wetting and flow characteristics on almost all ferrous and non-ferrous metals. Since it has a "0" plastic range, its strength remains relatively high even at service temperatures up to 350°F (175°C), this solder has better corrosion resistance and higher strength than ordinary soft solders, but the bonding temperature is much lower than the silver brazing alloys, therefore, it is the ideal intermediate alloy for joining.

APPLICATIONS:

Aluminum radiators, aluminum tube to copper tube in refrigeration and air conditioning units, sheet metal work, manufacture and repair of instruments, zinc base die casting and joining of dissimilar metals. Also for use on anodized aluminum.

TECHNICAL DATA:

Typical Tensile Strength	Up to 22,000 psi (152 N/mm ²)
Working Temperature	509°F (265°C)
Electrical Conductivity	Good
Corrosion Resistance	Good
Color Match	Very good on aluminum

Diameter	1/16 (1.6mm)
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PROCEDURE:

Thoroughly clean joint area. For best results maintain a joint clearance of no more than .006". Completely cover joint area with MG 460 flux; heat part with a soft flame being careful not to burn the flux. As soon as flux starts to bubble, dip solder into flux and transfer to joint, continue heating until solder flows through entire joint. Allow to cool. Remove all flux residue with hot water and stiff brush.