



MBO "ALUFIL" solder wire is carefully formulated to confer high activity soldering on aluminium and many of its alloys. Also suitable for use on most other metals to include stainless steel.

- Reliable soldering of aluminium and aluminium alloys
- High activity, good penetration
- Fast soldering
- Compatible with standard solders
- Good resistance to electrolytic corrosion
- Residues removed with water
- Low spattering

Alloy:

Alloy – Leaded Sn18Pb80Ag2

Melting Range:	178 – 270C
Density:	10.1g/cm ³
Composition:	Sn18Pb80.1Ag1.9
Electrical Conductivity:	8.7% of Cu
Tensile Strength:	3.8kg/mm ²

Available in 0.9mm and 1.6mm diameters – others on request

Alloy – Lead Free Sn97Cu3

Melting Range:	227 – 320C
Density:	7.3g/cm ³
Composition:	Sn97Cu3

Available in 2.0mm diameters – others on request

Physical & Chemical Characteristics:

Flux content:	2.5 +/- 0.5% (nominal)
Flux type:	Blend of Organic and inorganic compounds.
Residues:	MUST be removed with water.

Available in a range of diameters on 250gm, 500gm, 1kg and 3kg reels.

For **Application** and **Residue Removal**, see next page.



Application

Wrought aluminium alloys:

"Pure" Aluminium (up to 1% impurities)	Excellent
Aluminium-Manganese	Excellent
Aluminium + up to 3% Magnesium	Good
Aluminium + up to 1.5% each Magnesium & Silicon	Good
Aluminium Copper	Good
Aluminium + over 3% Magnesium	Poor

Cast Aluminium alloys:

"Pure" Aluminium (up to 0.5% impurities) Aluminium Copper	Good if rough cast surface is first machined off
Aluminium-silicon	Unsolderable

Other metals and alloys:

Tin plate, Copper, Brass, Nickel & Nickel Silver	Excellent
Steel, Stainless Steel and Zinc Alloy die castings	Good
Chromium, Titanium	Unsolderable

MBO "ALUFIL" solder wire confers rapid soldering with aluminium and many of its alloys. MBO "ALUFIL" solder wire can be used in conjunction with various methods of soldering, such as direct flame heating at soldering point. Blow torch. Electric or gas soldering iron, induction, hot plate, infra-red and resistance heating can all be considered depending upon the process employed. Care must be taken however at elevated temperatures since some carbonisation of the flux may result.

May be used in conjunction with MBO ALUGEL for more difficult to solder applications.

Residue Removal

Post-soldering residues of "MBO ALUFIL" solder wire MUST be removed with water.