



T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
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TECHNICAL SPECIFICATION SHEET

HARRIS ALBRAZE® 1070 ALUMINUM BRAZING FILLER METAL

ISO 9001
 Cert. No. 31598

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

NOMINAL CHEMICAL COMPOSITION:

1070 Wire (718)		1070 Flux	
Manganese	.15 max.	Sodium Chloride	25-45 %
Silicon	.11.0-13.0	Potassium Chloride	30-50 %
Zinc	.20 max.	Lithium Chloride	10-15 %
Iron	0.8 max.	Zinc Chloride	10-15 %
Magnesium	0.10 max.	Lithium Fluoride	4-10 %
Aluminum	Remainder		
Copper	0.30 max.		

PHYSICAL PROPERTIES:

1070 Wire		1070 Flux	
Color	Solid 1/16" Aluminum Wire	Color	White Powder
Specific Gravity	2.66	Specific Gravity	2.15
Melting Range	1070-1080° F (577-582 ° C)	Melting Range	Working Range 915-1115 ° F
Tensile Strength	Up to 35,000 psi	Tensile Strength	Working Range (491°F – 602°C)

BRAZING PROPERTIES:

Al-Braze 1070 wire is a superior brazing alloy used for torch, dip and furnace brazing of selected Aluminum base metals. Al-Braze is free flowing with unequaled capillary attraction, ductility and penetration with excellent corrosion resistance.

AVAILABLE FORMS:

Kits = ¾ oz. 1/16 wire diameter aluminum, 1/3 oz. aluminum flux
 Other sizes are also available for both the wire and flux (separately)

SPECIFICATION COMPLIANCE:

1070 Wire	1070 Flux
ANSI/ AWS A5.10 CLASS R4047 Q QB-655, BAISi4	ANSI/ AWS A5.31 FB1A AMS 3412

RECOMMENDED FLUX:

Al-braze 1070 flux is required except in vacuum brazing

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

Additional information available at our web site: www.harrisproductsgroup.com

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WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

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