



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  
4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

## TECHNICAL SPECIFICATION SHEET

ISO 9002  
Cert. No. 31598

### ALSOLDER® 500 ALUMINUM SOLDER

#### 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 SOLDER COMPOSITION:

Tin 85%  
Zinc 15%

#### PHYSICAL PROPERTIES: Mechanical properties of bulk solder

Solidus 391°F(199°C)  
Tensile Strength Up to 20,000 psi (Cu to Cu)  
Elongation in 2" 50%  
Liquidus 482°F(248°C)

#### SOLDERING PROPERTIES:

An intermediate temperature alloy useful for soldering aluminum to itself and other metals (not recommended for magnesium). Frequently used for repair of aluminum evaporators and soldering aluminum to copper tubing. When joining aluminum to dissimilar metals, the possibility of electrolytic corrosion must be considered. ALSOLDER 500 is also suited to repair zinc die cast alloys.

#### AVAILABLE FORMS:

Standard wire diameters  
Preformed Rings  
Kits 1-oz of each solder & flux

#### SPECIFICATION COMPLIANCE:

Harris Internal

#### RECOMMENDED FLUX:

Stay Clean Aluminum Flux  
Stay Clean Flux on other metals

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](http://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 (MSDS), 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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