



Product Information

Aluminium soft solder S-Zn96Al4

Soft solder for aluminium and aluminium alloys

Aluminium soft solder S-Zn96Al4 according to DIN 1707-100:2011-09

Art.-No.: 13463033

All information about our products are the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

Description

By using S-Zn96Al4 pure aluminium and aluminium alloys can be tinned and soft soldered with and also without any addition of flux. It is also suitable for connections of aluminium with copper in the air conditioning and refrigeration engineering. The tensile strength of the solder joint is as high as the aluminium itself!

Properties

Alloy:	96 % Zn, 4 % Al (S-Zn96Al4 according to DIN 1707-100:2011-09)
Density:	6,9 g/cm ³
Tensile strength:	67 N/mm ²
Melting point/Melting range:	382 - 387° C

Application

Without flux:

The parts to be joined have to be heated to work temperature (min. 400° C). Join the solder wire and keep on heating the work piece until the solder melts. Then with a sharp tool (scraper, screwdriver) or with the solder iron tip the oxide layer of the aluminium has to be broken up on the whole length of the connection. The solder infiltrates the oxide layer and hits the pure metal surface. The parts should cool down slowly and should not be moved until complete solidification of the solder.

Using FELDER Aluminium-Universal Flux ZnAl:

After cleaning the solder joint by rough impurities and grease, apply the FELDER Aluminium-Universal Flux on the areas which have to be connected. With heating up the soldering area the volatile solvents of the paste evaporate and the activators form a white, dry film. After reaching the soldering temperature the solder wire is then supplied. Optically to recognize is this, when the white salts of the flux clearly melt opens. During the solder supply the soldering area further can be heated up with the flame. An overheating of the Flux takes place only above 750°C (note: certain aluminum alloys melt already at 575°C!). When large volume components have to be soldered, it is recommendable to heat up the components first without flux! Dip the solder wire into the flux and bring it close to the solder joint.

Delivery forms

Massive wire 3,0 x 335 mm

Advices

Other alloys are included in our delivery program.
Do not hesitate to ask for more information.