

**AMTEC AS 406 ALUMINUM SOLDER**  
**FOR USE WITH OXY-ACETYLENE TORCH**

**General Characteristics**

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Amtec AS 406 is an economical low melting, self fluxing alloy for brazing aluminum and zinc based metals (white metal, zinc die cast, pewter, pot metal). AS 406 produces a sound joint, that is stronger than the parent metal, and is porosity free, clean and free from slag. Used to braze aluminum without flux, and can be used on galvanized steel to replace the galvanizing if it has been worn or burned off.

**Procedure**

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Clean the weld zone of all contaminants. Brush the surface to be joined with a stainless steel brush while heating the part, to break down any oxides present. Using a small tip, heat the metal hot enough to allow the alloy to flow by rubbing the rod back and forth across the heated part, thoroughly tinning the surface. With both parts tinned, heat and flow the alloy as required to complete the joint, ensuring that the filler alloy fuses with the tinned surface without melting the base metal. For welding zinc based metals, Vee parts to 45° and make sure surfaces are clean. Make sure when using the alloy that you push the rod back and forth through the flame on contact with the base metal to break down any oxide film, to guarantee a sound joint.

**Application**

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For the repair of aluminum boat hulls, aluminum propellers, aluminum castings, lawn mower housings, chain saw housings, die castings and pot metal parts.

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<b>Tensile Strength</b>	<b>47,300 PSI</b>
<b>Compressive Strength</b>	<b>93,100 PSI</b>
<b>Impact Strength</b>	<b>15 (Charpy)</b>
<b>Elongation</b>	<b>8.4%</b>
<b>Hardness (HB)</b>	<b>83</b>
<b>Modulus of Rupture</b>	<b>116,000 PSI</b>
<b>Melting Point</b>	<b>732°F</b>

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<b>Diameter (Inch)</b>	<b>1/8</b>
<b>(mm)</b>	<b>3.25</b>

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**CONFIDENTIAL INFORMATION**  
**Subject to change without notice**

**Tip Color – Plain**  
**No Imprint – Bare Rod**