



# HSM Wire International, Inc

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## Brazing Aluminum

Modern Techniques of brazing aluminum have been established as an important mass production method over the past decades. Some of brazing's advantages are summarized below:

- Joining of components of very small thickness
- Joining of aluminum alloys to dissimilar metals
- If welding temperatures required which are not permissible
- If small distortion of components is required
- If large scale joint areas
- Compact components containing many junctions per unit of area
- Less personnel training required
- Meniscus surface formed by the filler metal is ideally shaped for good fatigue properties
- Finishing costs are low

Designation EN-AW	Approximate Temperature (°C)			Relative Brazeability
	Solidus	Liquidus	Recommended Brazing Range	
1050A	646	657	596 615	A
3003	643	654	593 615	A
3103	640	655	593 615	A
3004	629	654	582 604	B
5005A	630	650	582 604	B-C
5052	593	649	571 593	C
5056A	575	630	- -	D
6061	593	652	565 585	B
6063	616	652	565 585	A
6951	616	654	- -	A
2017A	512	650	- -	E
7075	480	640	- -	E

**\*To be used as a guideline only \*\*We do not necessarily sell all products listed**

A= alloys readily brazed by all techniques

B= alloys that can be brazed by all techniques with some extra care experience

C= alloys that require special care and effort

D= alloys difficult to Braze

E= alloys not suitable to Braze