

Technical Data Sheet

52 Brazing Alloy The High-Strength Alloy



Cronatron™
A LAWSON BRAND



Overview

52 Brazing Alloy is an aluminum alloy solder that offers exceptionally high strength characteristics. Special alloying ingredients allow 52 Brazing Alloy to be self-fluxing on a wide variety of aluminum, magnesium and zinc base metals.



Features/Benefits

- Self-fluxing
- Easy to use
- Fills holes
- Exceptional strength
- Bridges gaps
- Contains no lead or cadmium

Applications

- Machine guards
- Aluminum pipe frames
- Gear boxes
- Aluminum pipe repairs
- Casting defects
- Mower housings
- Propeller repairs
- Pump housings

Method of Application

Torch

Identification

White tip on bare aluminum rod

Directions for Use

Heat base metal using a 1-X acetylene feather flame. Melt off a small amount of 52 Brazing Alloy and scrub (tin) area of repair using a clean stainless steel wire brush. Use circular motion with torch when applying buildup or repair alloy. Copper or carbon block is suggested as a chill bar when soldering thin sections.

Technical Specifications

Tensile Strength: 40,000 PSI (276 MPa)
Bond Strength: 28,000 PSI (193 MPa)
Shear Strength: 45,000 PSI (310 MPa)

Electrical Conductivity: 25% IACS*
Bonding Temperature: 720°F (382°C)

*International Annealed Copper Society

Technical Tips

After tinning, bring filler to surface at 90° angle and manipulate torch in a circular motion at 45°. Avoid overheating base metal. Use clean torch tip to precisely control heat input.

