

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