

FONTARGEN A 604 KA

Friction solder, build-up soldering (lead-free)



DIN EN ISO 3677: S-Sn90Zn7Cu3

Composition, typical analysis (% w/w):

Zn	Cu	Sn
7	3	Remainder

Mechanical and physical properties:

Melting range: 200 - 250 °C

Hardness (BHN): 16 HB

Electrical conductivity: 22.6 Sm/mm²

Specific gravity: 7.3 g/cm³

Characteristics / Applications:

Step-by-step solder (first solder). Sealing of blowholes and cracks on cast iron and cast aluminium, repairs on zinc injection moulded parts, filling-up of dents in aluminium plates. Auto body workshops, aluminium foundries, repair shops, etc.

In application to steel auto bodies like the correction of detriments and cracks, AP 644/12 must be applied beforehand (also see FONTARGEN work assembly auto body solder).

Friction solder, on aluminium without flux. Build-up possible. A 604 KA is an enhancement of A 604.

Heat sources:

Acetylene torch (fuel gas excess), air-gas torch, soldering lamp, soldering Iron

Flux:

F 600 Al

Availability:

Bare rods	Coated rods	Wire	Foil	Preforms	Powder	Paste
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