

# FONTARGEN A 604

## Friction solder



DIN EN ISO 3677: S-Sn60Zn40

### Composition, typical analysis (% w/w):

|    |           |
|----|-----------|
| Sn | Zn        |
| 60 | Remainder |

### Mechanical and physical properties:

|                          |                         |
|--------------------------|-------------------------|
| Melting range:           | 200 - 340 °C            |
| Hardness (BHN):          | 19 HB                   |
| Electrical conductivity: | 22.2 Sm/mm <sup>2</sup> |
| Copper:                  | 100 N/mm <sup>2</sup>   |
| Brass:                   | 90 N/mm <sup>2</sup>    |
| Steel:                   | 90 N/mm <sup>2</sup>    |
| Specific gravity:        | 7.1 g/cm <sup>3</sup>   |

### Characteristics / Applications:

Lead-free friction solder, on aluminium without flux. Build-up possible. 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. Car body workshops, aluminium foundries, repair shops, etc.

### 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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