



TECHNICAL SPECIFICATION SHEET

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WELCO 52

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS (INFRARED RADIATION) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheet (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

STATEMENT OF LIABILITY — DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. J.W. Harris Co., Inc. and its affiliates shall have no liability in respect thereof.

NOMINAL COMPOSITION:

Aluminum	3.75-4.00 %
Copper	2.15-2.50 %
Zinc	Balance

PHYSICAL PROPERTIES:

Melting point	732°F (225°C)
Color	Bright Silver
Self fluxing on aluminum	
Tensile Strength	39,000 psi



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SOLDERING PROPERTIES:

Used on Zinc die cast, remove all dirt, scale, oxide and plating from joint area. Preheat to 400° F and sprinkle Welco 52 flux in the joint area using a backing plate on thin section and bevel thicker sections. Heat the fluxed area and add the alloy a small amount at a time allowing it to flow. Use a neutral flame and incline the torch in the direction of travel. Aluminum must be cleaned and should not need a flux - rub the rod on the heated part until the alloy melts and flows. TIG welding use argon and AC High frequency.

AVAILABLE FORMS:

1/8" (3.2 mm) x18" (450 mm)

SPECIFICATION COMPLIANCE:

INTERNAL

RECOMMENDED FLUX:

WELCO 52 FLUX, SELF FLUXING ON ALUMINUM

J.W. Harris Co., Inc.
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For technical support and product information, visit our web site at www.jwharris.com

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