



**T H E H A R R I S P R O D U C T S G R O U P**  
**A L I N C O L N E L E C T R I C C O M P A N Y**  
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**TECHNICAL SPECIFICATION SHEET**

ISO 9002  
 Cert. No. 31598

**COR-AL ALUMINUM BRAZING FILLER METAL**

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. Harris Products Group, and its affiliates shall have no liability in respect thereof.

**NOMINAL CHEMICAL COMPOSITION:**

Silicon	6.0 % max	Magnesium	6.0 % max
Iron	1.0 % max	Zinc	.50 % max
Copper	.50 % max	Titanium	.50 % max
Manganese	1.0 % max	Chromium	.50 % max
Aluminum	Remainder		

**PHYSICAL PROPERTIES:**

Melting Range	1055-1155 °F (568-623°C)	Color	Bright Shiny Copper
Tensile Strength	Up to 30,000 psi		

**BRAZING PROPERTIES:**

WELCO COR-AL is a tubular aluminum rod with an precisely calibrated ratio of flux, assuring versatile performance. Surface should be ground and beveled along with being clean, free of dirt, grease and oxides. Use a slightly carburizing flame with brazing technique 1" to 3" from the surface and remove flux residue with a warm water rinse. Deposit small amounts of the alloy and allow it to flow out on the work area. For built up work, reduce the heat and play the flame on the filler rod just above the work area and melt drops of the filler rod into the work piece. Crimp the ends of rods after use to seal in the unused flux.

**AVAILABLE FORMS:**

1/8" (3.2mm) & 3/16" (4.8mm)

**SPECIFICATION COMPLIANCE:**

Harris Internal

**RECOMMENDED FLUX:**

Separate flux is generally not used with COR-AL, although WELCO 10 may be used in addition to insure flow ability and cleanness on the base metal.

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Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)

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

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- 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.

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