



Consolidated Alloys

A Division of C.A. Group Australasia Pty. Limited inc in Vic.
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ALLOY CA 24

PRODUCT DESCRIPTION Aluminium Rub On Solder

APPLICATIONS Repair to aluminium products.

AVAILABLE FORMS

- Cast rod approx 5 – 6mm in diameter x 300mm in length.
- Approx weight per rod 48grams

SPECIFICATION

TYPICAL PROPERTIES

Tensile Strength	245 - 250 MPA
Hardness	95 - 105 Brinell
Solidus	375°C (approx)
Liquidus	380°C (approx)

TYPICAL PROPERTIES ARE APPROXIMATE ONLY

DATA SHEET Alloy CA 24 is a cast rod of approx sizes 5-6mm in diameter x 300mm in length, which uses the rub-on process on aluminium.

This material is commonly used for repairing of aluminium related products, such as Casting, Engine Parts, etc.

PROCEDURE Cracks & joints should be beveled to a 60° to 90° vee. Remove all dirt, grease, and any foreign materials for components to be repaired.
Using a welding gas torch (carburizing flame) as the temperature approaches 360-380°C rub the rod on the surface to be soldered.
Continue to apply heat to the base material until the rod melts into the joint.
DO NOT OVERHEAT.
Allow soldered part to cool slowly.

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