



TECHNICAL SPECIFICATION SHEET

HARRIS PRODUCTS GROUP
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HARRIS ALBRAZE® 1070 ALUMINUM BRAZING FILLER METAL

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 (MSDS), 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 CHEMICAL COMPOSITION:

1070 WIRE (718)

Silicon	11.0-13.0
Iron	0.8 max.
Copper	0.30 max.
Manganese	0.15 max.
Magnesium	0.10 max.
Zinc	0.20 max.
Aluminum	Remainder

1070 Flux

Sodium Chloride	25-45%
Potassium Chloride	30-50%
Lithium Chloride	10-15%
Zinc Chloride	10-15%
Lithium Fluoride	4-10%

PHYSICAL PROPERTIES:

	1070 Wire	1070 Flux
Color	Solid 1/16" Aluminum wire	White powder
Specific Gravity	2.66	2.15
Melting Range	1070-1080°F(577-582°C)	Working Range 915-1115 °F
Tensile strength	Up to 35,000 psi	Working Range (491°-602°C)



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BRAZING PROPERTIES:

Al-Braze 1070 wire is a superior brazing alloy used for torch, dip and furnace brazing of selected Aluminum base metals. . Al-Braze is free flowing with unequaled capillary attraction, ductility and penetration with excellent corrosion resistance.

AVAILABLE FORMS:

Kits = ¾ oz. 1/16 wire diameter aluminum, 1/3 oz. aluminum flux
Other sizes are also available for both the wire and flux (separately)

SPECIFICATION COMPLIANCE:

1070 Wire	1070 Flux
ANSI/AWS A5.10 Class R4047	ANSI/AWS A5.31 FB1A
QQB-655, BAISi4	AMS 3412

RECOMMENDED FLUX:

Al-braze 1070 flux is required except in vacuum brazing

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