



# Soft Solder and Self Fluxing Aluminum Alloys

**FOR U.S. JOBS**  
UNIWELD EMPLOYS OVER 300 WORKERS

Uniweld's UNI-4300 aluminum soft solder kit with metal tip flux applicator is a great solution for the service technician who is frequently confronted with the task of repairing or joining aluminum to aluminum and aluminum to copper or brass. A common repair problem occurs when an air conditioning system's evaporator coil develops a small pinhole leak.

**JOINS ALUMINUM, COPPER AND BRASS**

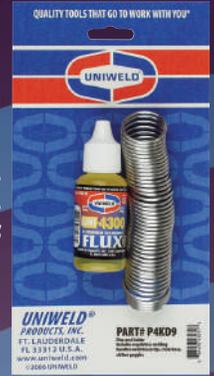
UNI-4300 is an excellent product for this repair application due to its low melting point of 500 °F [260 °C] and 20,000 PSI tensile strength.

*For best results, prepare the tubing by cleaning the surface and removing any oil, grease and oxides. To remove the oil and grease, use a chemical solvent. The oxides should be removed using only a stainless steel wire brush or emery cloth.*

**TUBING SURFACES MUST BE CLEAN.**

When making a repair on an evaporator coil, it will be necessary to preheat the tubing prior to applying the flux. A common mistake when making this type of repair is to apply the flux and then begin heating the tubing. The evaporator coil disperses the heat and the tubing never reaches the melting temperature of the alloy. The flux then overheats and burns, then becomes an inhibitor that doesn't allow the alloy to bond properly to the base metal.

Preheat the evaporator tubing and then apply the flux using the metal tip flux applicator. Continue applying heat until the flux starts to bubble and then apply the UNI-4300 solder into the area being repaired.



P4KD9



P4KD9S



## UNI-4200 Self Fluxing Aluminum Rods

Used for joining and repairing aluminum extrusions and castings. Also can be used for the manufacture and repair of aluminum doors and windows, repairing ladders, gutters, siding, aluminum boats and instrument boxes. Most kirksite and zinc based dies can be repaired with this alloy. May also be used as wear-facing alloy on aluminum.



P3KH9

Part#	Description
P3KH9	UNI-4200 Self fluxing Aluminum rods
P4KD9S	UNI-4300 Aluminum solder [10 ft. coil] with a 2 oz. flux bottle & metal tip flux applicator
P4KD9	UNI-4300 Aluminum solder [10 ft. coil] with a 1 oz. flux bottle
F6CYAK	UNI-4300 2 oz. flux bottle
F6CYL	UNI-4300 1 oz. flux bottle

