

AL 714

NOMINAL COMPOSITION

Aluminum	Remainder
Silicon	10.0% ± 1.0%
Copper	0.30% Max
Iron	0.80% Max
Magnesium	0.05% Max
Manganese	0.05% Max
Zinc	0.10% Max
Titanium	0.20% Max
Other Elements (Each)	0.05% Max
Other Elements (Total)	0.15% Max

PHYSICAL PROPERTIES

Color	Grayish-White
Melting Point (Solidus)	1070°F (577°C)
Flow Point (Liquidus)	1110°F (599°C)
Brazing Range	1090°F - 1120°F (580°C - 605°C)
Specific Gravity	2.79
Density (Lbs/in ³)	0.101
Electrical Conductivity (%IACS) ⁽¹⁾	N/A
Electrical Resistivity (Microhm-cm)	N/A

⁽¹⁾ IACS = International Annealed Copper Standard

PRODUCT USES

AL 714 is a general purpose brazing filler metal to join aluminum and aluminum alloys, generally when a more sluggish alloy is needed to bridge wide gaps. When joining dissimilar metals thought should be given to the galvanic potential between the metals to avoid galvanic corrosion problems. To maintain joint integrity on heat treatable aluminum alloys, the solution temperature must be below the solidus of the filler metal.

PROPERTIES OF BRAZED JOINTS

The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design, metallurgical interaction between the base metal and the filler metal. Joint clearances of 0.003 - 0.005 in. (.076-.127 mm) per side are optimum for achieving highest joint strength. Joints with increased clearances can still produce adequate joint strengths depending on final operating conditions.

AVAILABLE FORMS

Strip, powder and paste.

SPECIFICATIONS

AL 714 alloy conforms to the following specifications:

- Aluminum Association (AA) 4045
- American Welding Society (AWS) A5.8/A5.8M BAlSi-5

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 62-714.

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for AL 714.

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