Aladdin

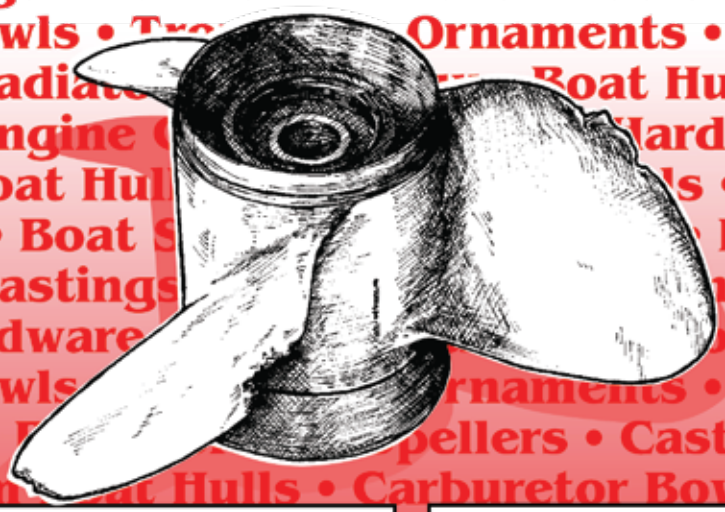
3 in 1 ROD

REPAIRS ALL ...

Aluminum and Zinc Alloys quickly and easily.

For use with acetylene, propane, and mapp gas.

Engine Castings • Marine Hardware • Tools • Propellers • Carburetor Bowls • Tr… Ornaments • Boat Seats • Kirksite Dies • Radiat… Boat Hulls • Castings • Lower Units • Engine … Hardware • Tools • Aluminum Boat Hul… …ls • Trophies • Ornaments • Boat S… Radiators • Propellers • Castings … Castings • Marine Hardware … Boat Hulls • Carburetor Bowls … rnaments • Boat Seats • Kirksite Dies • … pellers • Castings • Lower Units • Aluminum … Hulls • Carburetor Bowls • Trophies •



Another fine Aladdin product available from your Distributor and

Aladdin Welding Products

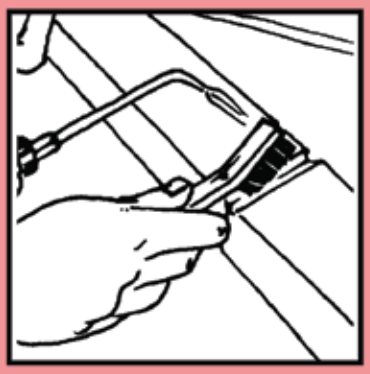
Toll Free: 1-800-346-5368
Fax: 1-877-346-5368
www.Aladdin3in1.com

"Personal Service For Over 85 Years"

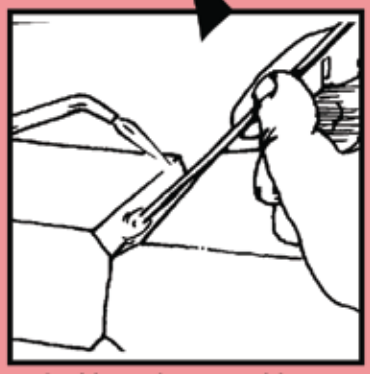
Aladdin 3 in 1 ROD -

- Melting Point: 732° F
- Meets MIL-R-4208
- Available in 7 diameters from 1/32 to 1/4 inch, in 18 and 36 inch lengths
- NO FLUX REQUIRED!

How to Braze Aluminum with Aladdin 3in1 ROD

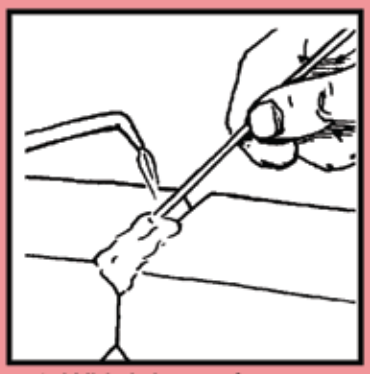


1. Brush surface to be repaired thoroughly under heat to break up surface oxide.



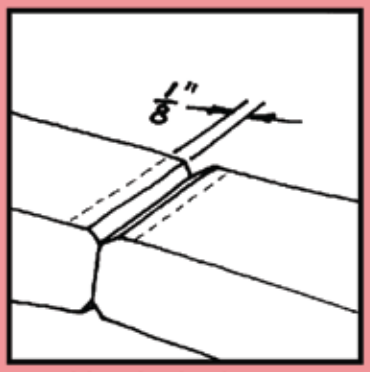
2. Heat the metal hot enough to flow the rod without the aid of the flame, thoroughly tinning the surface.

3. Brush tinned surface under heat, thoroughly filling the open pores.

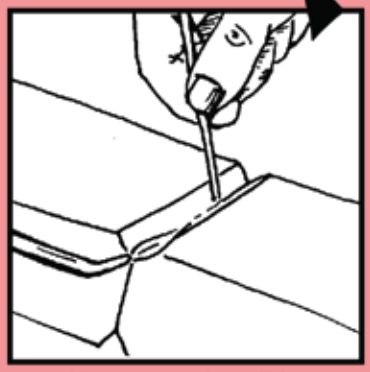


4. With joint surfaces thoroughly tinned, flow in enough rod to fill the vee. Be sure filler metal fuses with the tinned surface without melting the base metal.

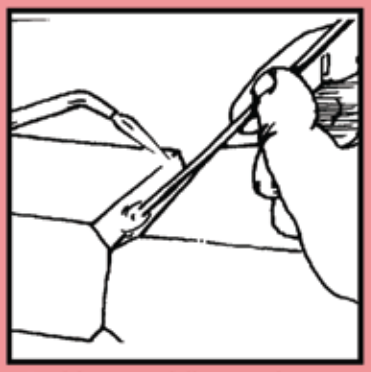
How to Weld Zinc-Base Metals with Aladdin 3in1 ROD



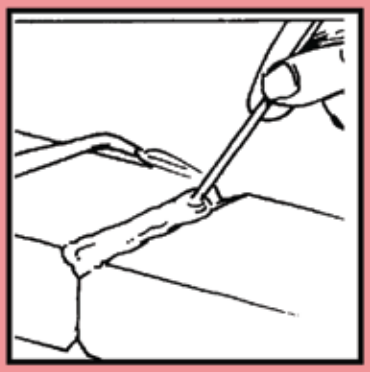
1. Vee the broken edges of the area to be repaired to about 45°. Clean the surface of any plating or scale back from the edges of the vee 1/8 of an inch.



2. Heat metal until it starts to flow. Turn flame parallel to surface, and hold metal at this heat with the indirect flame.



3. Heat welding rod to same temperature. With both the base metal and rod at this temperature, touch the rod to the break. It will flow into the vee, fusing thoroughly.



4. Continue until break is completely filled. Be sure to kick rod into weld to break down skin resistance or filler rod will lay on the surface and will not fuse.

Repair Example: Repairing a Propeller

1. Wire brush thoroughly to break up any surface oxide and to remove paint. Grind the damaged edges to a 45° bevel.

2. Heat metal hot enough to flow rod without the aid of the flame. Tin the flat side of the blade and attach a piece of carbon or copper to support the repair temporarily.

3. Turn and tin the beveled surface, building new metal until slightly larger than its original size. Remove temporary support with minimal heat.

4. Let the repair cool, then grind to proper pitch standards. You now have a complete repair without porosity ready to balance and paint.