SEEK KNOCK ASK
Excellent Solutions Provider skabrazing.com

Technical Data Sheet

CL Series (CL200 and CL150) Brazing Filler Metal

C denotes a flux cored type brazing filler metal, while L indicates that the filler metal is primarily composed of aluminum and zinc.

NOMINAL COMPOSITION

Aluminum	22.0% ± 1.0%
Zinc	Remainder
Other Elements (Each)	0.05% Max
Other Elements (Total)	0.15% Max

PHYSICAL PROPERTIES

Color	Dark Grayish
Solidus	800°F (441°C)
Liquidus	900°F (482°C)
Brazing Range	900°F ~ 1000°F (482°C ~ 537°C)
Density (Lbs/in^3)	0.190
Specific Gravity	5.25
Electrical Conductivity(%IACS)(1)	N/A
Electrical Resistivity (Microhm-cm)	N/A

(1) IACS = International Annealed Copper Standard

USES

The CL series is a general-purpose aluminum brazing filler metal designed to join all brazeable grades of aluminum and aluminum alloys, as well as aluminum to copper.

BRAZING CHARACTERISTICS

The CL series has a low melting point, making it suitable for brazing aluminum alloys and joining aluminum to copper.

PROPERTIES OF BRAZING JOINTS

The characteristics of a brazed joint rely on several factors such as the properties of the base metal, the design of the joint, and the metallurgical relationship between the base and filler metals.
For aluminum brazed assemblies, optimal joint clearances are between 0.003 and 0.005 inches (0.076 to 0.127mm) on each side to achieve maximum joint strength. However, joints with larger clearances can still achieve sufficient strength based on the eventual operating conditions.

SPECIFICATIONS

The CL series conforms to: N/A.

AVAILABLE FORMS

The CL series is available in rings, paste, wire, rods, and engineered preforms, based on customer specifications.

FLUX DATA

The flux levels for the CL series are 20% and 15%, corresponding to the product names CL200 and CL150, respectively.

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.”

DISCLAIMER

The information provided in this publication is for general informational purposes only.
While every effort has been made to ensure accuracy, the manufacturer or supplier does not guarantee the completeness or reliability of the data. Users must follow all applicable safety guidelines, industry standards, and regulatory requirements when handling and using brazing materials.
The manufacturer or supplier is not liable for any damages, injuries, or losses resulting from improper use, storage, or application of these materials. Always consult technical documentation and seek professional advice before proceeding with any brazing process.