

# ZACLON LLC ZACLON ALLOY REPAIR RODS

ZACLON LLC is pleased to provide a zinc based lead free alloy for touch-up of defects and damaged areas on hot-dip galvanized surfaces manufactured by Gardiner Metals in Chicago, Illinois.

This product was developed under the International Lead Zinc Research Organization, Inc. (ILZRO) Project ZM-377 Improved Touch-Up Methods for General Galvanized Products. (The American Galvanizers Association helped fund this project.) These alloy sticks provide both desired thickness control at steep application angles and moldability required for obtaining smooth touch-up repairs.

ZACLON ALLOY REPAIR ROD, also designated as alloy 911, provides excellent adhesion properties with good appearance and high resistance against corrosion and abrasion. The addition of 1% copper in this unique alloy results in good microstructure which allows greatly improved control in applying an even coating compared to existing methods.

Specifications: Alloy - 50% tin, 49% zinc, 1% copper  
Size - .250" dia. x 14" (50 pound box)

Application:

1) Shot blast and/or wire brush surface and apply a thin layer of flux or tinning compound.

2) Heat surface with propane or gas air torch. Newly galvanized work can be repaired directly out of the kettle without heating.

3) Apply solder bar to steel surface while heating to melt solder as soon as possible. Lay down a thin layer to tin the whole area to be repaired entirely and then build up as desired.

4) Allow the solder to solidify, smoothing as needed. Use a pyrex glass rod in a file handle to smooth out repair alloy.

5) Remove flux residues with a wet cloth or paper towel while the surface is still warm.

For additional safety information, please review the MSD sheet.

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