Blue Demon Triple Play Aluminium Brazing Rod

TRIPLE PLAY

ONE ROD, THREE APPLICATIONS!



Blue Demon Triple Play is the perfect choice for a quick repair of all aluminum and zinc alloys including ladders, lawn furniture, awnings, aluminum radiators, power tools, propellers, castings, boat hulls, hardware accessories, dies, and much much more!

- No flux required
- Welds zinc base metals
- Brazes aluminum
- Solders galvanized metal without the use of flux
- Simple to use with only a propane torch
- Super Low melting point (732°F)
- Excellent corrosion resistance
- Repairs as little as $.05 per inch!
- Stronger than aluminum
- Harder than mild steel

BDTP-125-01T 1/8" X 18" X 1 LB TUBE

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Simple and easy, do-it-yourself aluminium repair in 3 easy steps!

1. Clean the surface with a stainless-steel brush
2. Heat the base metal surface, not the "Triple Play"
3. Apply the "Triple Play" to the heated surface

- Aluminium Zinc Brazing rod for aluminium repair and dissimilar metal brazing
- Melts at 385ºC (730ºF)
- Excellent corrosion resistance
- Flux not required
- .004" to .005" weld depth is all that is required for maximum strength

Tips For Use:

Clean aluminium down to bare metal using a stainless-steel brush, getting off all dirt, paint and coatings. Cleanliness is essential for a strong permanent joint.
In some cases, a thin layer of insoluble oxide will occur on the surface of the base metal. This is typically caused by impurities in the base metal and form as you are heating the metal. The oxide must be removed or penetration will not occur. When you puncture this layer with the Triple Play rod it breaks up into a fine powder and floats to the surface of the molten puddle. You can actually see it appear on the surface. Draw the Triple play rod through the puddle several times to remove oxides and promote fusion with the base metal. A few strokes are usually enough.

Localizing of heat techniques can also be utilized to improve the shape of the fillets. If you are joining two pieces of different sizes you will want to apply most of the heat to the larger piece so that they both arrive at the working temperature at about the same time. The repair will harden in a few seconds and can be worked immediately. Do not immerse in water to speed the cooling. The material will be quite hard. It will grind, machine, drill, tap and paint much like a mild steel. Yet when fused with aluminium it is not brittle unless it is cooled too quickly.
For most jobs, a propane (LP) gas torch is enough. Make sure to reach working temp of 730ºF. Use a general-purpose tip. For heavy pieces you will need a fuel-oxygen torch. If so, use a large tip with a neutral flame to spread the heat evenly. Only heat with the middle or outer cones of the flame.

T-Joints: Heat the parts, not the Triple Play and flow the Triple Play into the intersection. Run the solid end of the Triple Play stick through the molten Triple Play to remove any trapped oxide.

Butt Joints: If the ends are bevelled at 45º angles clean the surfaces and then heat separately. After cooling, brush both pieces again to remove the oxide layer that has formed. Reheat both parts equally and fill in the groove with Triple Play. Cool slowly by fanning the hot weld with your propane torch as you gradually move away.

Lap Joints: Parts can be tinned and slid together while triple Play is molten, or a generous fillet of Triple Play can be applied around the edges of the lap joint.

Metered Joints: Make sure material is solidly clamped in place. A neutral flame is applied over the joint area until Triple Play melts along the joint. The joint may be built up and finished as desired.

Stripped Threads: Drill old threads out oversized so when filled with Triple Play all drilling and taping will be done with the same material making it easier to work with. After drilling, heat base metal from the bottom of the hole beginning at the bottom and working your way up. Fill the hole, let cool, drill and tap as needed.