

## DIFFUSALLOY 181 C

Diffusaloy 181 C is a self fluxing high strength flexible flux coated filler wire rod of Bronze alloy for joining and overlaying cast irons, mild and low carbon steels, brass, copper and for joining dissimilar metals.

### Applications:

For steel, cast iron, copper, brass, dissimilar metals joining like steel to cast iron, copper to copper alloys. Spur gear teeth, bearing surfaces and shafts.

### Procedure:

Clean / degrease joints with CTC or TCE.

Use neutral oxy acetylene flame.

On cast iron sear the weld area with excess oxygen flame before preheating.

Feed the filler alloy into the flame and deposit till joining or build up is achieved.

Flame machine to obtain smooth deposit.

Wash off flux residue in warm water.

### Technical Data

: **DIFFUSALLOY 181 C**

Size (mm), Ø	:	3.15
Ultimate tensile strength	:	upto 65 kgf/mm <sup>2</sup>
Brazing temperature	:	780 <sup>0</sup> C
Remelt temperature	:	890 <sup>0</sup> C
Hardness	:	180 BHN (As deposited)
	:	230-240 BHN (Work hardened)

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