

DIFFUSALLOY 202

A low-melting, self-fluxing alloy for joining copper assemblies and for joining copper-base alloys. This thin flowing alloy is recommended for close-fit joints on copper and copper-base alloys.

Applications:

For joining thin sheets, tube-sheet assemblies, copper radiator tube production and repairs, induction heating coil, copper mould repairs, electric motor manufacture, joining rotor bars to rings, commutator joints, electrical contacts, refrigeration tubes and assemblies, fuel and lube oil lines of automobiles etc.

Procedure:

Clean/degrease joints. For copper assemblies, heat the base metal to dull-red heat using oxyacetylene neutral flame. Melt off a small quantity of alloy by feeding the filler rod into the flame on the joint. Move the flame along the joint to flow the alloy. For joining copper to copper alloys, pre-place Diffusion Flux 202 with a small hair brush and heat the assembly till flux melts and flows. Melt off a drop of alloy and move flame along joint to flow the alloy. Wash off flux residue in warm water.

Technical Data:

Size (mm)	:	1.6	3.15
Ultimate Tensile Strength	:	35 kgf / mm ²	
Brazing Temperature (approx.)	:	660 ⁰ C	
Tip Colour	:	Red	

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