

DIFFUSALLOY 252

A high silver brazing alloy for high strength and for thick and thin flowing applications. Ideal for tungsten carbide tipping, carbon alloy steels, stainless steels, nickel alloys, copper and copper alloys and dissimilar metals. For lap, 'T' square butt and flange joints.

Applications:

Tool room applications like joining HSS to shanks, repairing broken milling cutters, drills, taps, reamers and carbide tipping, saw blades, for thin and dissimilar gauge metals. For joining parts used in refrigeration, air-conditioning units, automotive parts and accessories, electrical equipment, machine tools and instruments.

Procedure:

Clean/degrease joints with CTC/TCE. Leave 0.75mm gap between joints to obtain high strength. Apply \ Diffusion 252 Flux on the rod and joint area. Clamp parts if necessary. Heat broadly with excess acetylene \flame, keeping 25 to 75mm distance between flame cone and base metal, and heat until flux liquefies. Keep torch in constant motion, and allow alloy till it flows completely through the joint. Remove flux residue.

Technical Data:

Size	(Rod)	:	1.60mm dia.
	(Shim)	:	0.12 x 25mm
Ultimate Tensile Strength		:	50 kgf/mm ²
Brazing Temperature		:	640°C
Tip colour		:	Brown.

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