

LH 210 SF

Flexible coated special brass brazing alloy with good strength

ALLOY BASIS

Cu, Zn, Additives

PROPERTIES

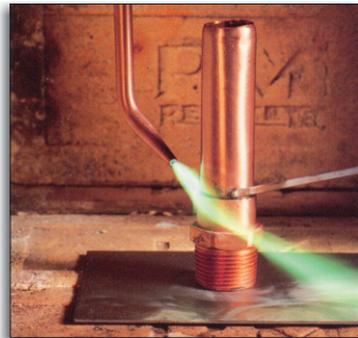
LH 210 SF is a flexible flux coated rod which can be used directly on the job without separate application of flux. The operation becomes very fast and economical. The flux is so flexible and thin that on bending the rod through 180° the flux coating does not peel off. Hence it has an extended life span.

TECHNICAL DATA

UTS : upto 45 kgf/mm²
Melting range : 890-900° C

TYPICAL APPLICATIONS

Joining and surfacing of steel, cast iron, copper, brass. Also for galvanized iron, joins dissimilar metals like steel to cast iron, steel to copper & copper alloys, cast iron to copper & copper alloys, etc. Excellent for sheet metal assembly and repair. Well suited for repair of car bodies and car silencer assembly where it can be used on overhead position without dismantling.



PROCEDURE

Clean the joint thoroughly. Use neutral flame. Preheat a broad area and then heat locally until flux melts. Then melt the filler rod and apply on to the joint. For capillary joints melt the rod and draw with the flame along the joint. In case of cast iron, preheat the entire casting to 450° C and maintain this preheat until the operation is completed.

Cleaning: Remove flux residues mechanically or chemically (using 10% hydrochloric acid for ferrous metals and 10% sulphuric acid for copper and its alloys) followed by rinsing in running water.

Heat Source: Acetylene torch, furnace, high frequency induction.

AVAILABILITY

Size (∅ mm)/Length : 1.6x500 2.5x500 3.2x500



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