



Solenoid Valve Piston

## Flux coated brazing alloy for built up & overlay application on all ferrous and non-ferrous alloys

### Typical Applications:

Gear teeth, shafts, bearing seat, pistons sprockets, pump bodies, impellers, wear pads, guides.

### Outstanding Features:

- Dense deposits with low coefficient of friction.
- Excellent corrosion resistance.
- Highly machinable.
- Excellent control on multi-pass build-ups.
- Deposits work harden in service.
- Deposits are flame machinable.

### Recommendation:

For build-up and overlay applications on all ferrous and non-ferrous alloys except white metals. Superior brazeability and control. Ideal for building up broken or worn gear teeth, worn bearing areas, valve seats and pistons.

### Procedure:

Clean and degrease joint areas. Pre-heat parts. Deposit initial tinning layer of the alloy. Melt off drop of flux from end of rod to the beginning of joint area. Continue heating until flux liquefies. Deposits alloy drop by drop, feeding into flame as required, making sure that each drop bonds properly. Air cool. Remove flux residues by washing with water. Use EWAC BR 585 flux for supplementary requirements. Additionally the deposits can be flame machined using oxy-acetylene flame.

### Size:

Size (mm)
3.15
5.00

**Bonding Temperature:** 875°C

**Tensiles Strength:** 600MPa (87,000 psi)