

## DIFFUSALLOY 155 C

A general purpose brazing alloy for joining mild, low carbon and galvanized steel, copper and copper- base alloys.

### Applications:

For fillet and butt joints on mild steel, low carbon and galvanized steel sheets, tubes and plates; dissimilar joints between steel and copper, brasses and bronzes.

### Procedure:

Grind/bevel, clean/degrease joints. Preplace Diffusion Flux 155 on the joint. Heat uniformly till the flux melts and flows. Use a neutral oxyacetylene flame. On cast iron, sear the weld area with excess oxygen flame before preheating. Feed the filler alloy into the flame at the joint. Melt the alloy, moving the flame to obtain smooth fillet or butt/profile. Allow the assembly to cool to ambient temperature. Wash off flux residue in warm water.

### Technical Data:

Size	:	3.15mm dia.
Ultimate Tensile Strength	:	upto 45 kgf / mm <sup>2</sup>
Brazing Temperature	:	820 <sup>0</sup> C - 870 <sup>0</sup> C
Coating Colour	:	Green

### DIFFUSION ENGINEERS LIMITED

Regd. Office & Works I : T-5/6, M.I.D.C, Hingna Industrial Area, Nagpur-440 016, (T) 091-7104-232084, 234727 (F) 232085

Works II : N-78/79, MIDC, Hingna Industrial Area, Nagpur – 440 016. (T) 091-7104-236036

Works III : T-12, MIDC, Hingna Industrial Area, Nagpur – 440 016.(T) 091-7104-232984

Email : info@diffusionengineers.com Website : www.diffusionengineers.com

Branch Offices : Chennai, Faridabad, Jamshedpur, Pune, Raipur, Secunderabad, Vadodara.