

DIFFUSALLOY 242

High tensile, low bonding temperature, silver type alloy for high strength joining of all metals except white metals. Excellent for joining brass, mild and alloy steels to stainless steel. Provides high strength joints with little or no finishing and no melting of base metal.

Applications:

For joining mild and alloy steels and tubular steels to stainless steels, thin flow applications on lap, 'T' square, butt and flange joints. Ideally suited for thin and dissimilar gauge metals. Excellent for toolroom applications.

Procedure:

Clean joint area with CTC/TCE. Leave 0.75mm gap to obtain high strength joints. Apply 242 flux on 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 apply alloy till it flows completely through the joint. Remove flux residue.

Technical Data:

Size	(Rod)	:	1.60mm dia.	And	3.15mm dia.
	(Shim)	:	0.12 x 25mm		
Tensile Strength		:	42 kgf / mm ²		
Bonding Temperature		:	660 ^o C		

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