



**Bearing Housing**

## **Solder paste for dissimilar metal joining except Mg and Al.**

### **Typical Applications:**

Instruments, gauges, tinning, radiator repair, costume jewellery.

### **Outstanding Features:**

- Paint-on solder-flux paste.
- Application in paint or paste form.
- All purpose - for use on all metals except aluminium and magnesium.
- Easy to use - place and indirect heat.

### **Recommendation:**

A newly formulated paint-on solder paste combined with flux. Recommended for soldering dissimilar metals other than aluminium and magnesium. Ideal for applications where preplacement of solder is required for furnace and automatic soldering. Low temperature soldering alloy good fluidity and joint strength. For torch, furnace or solder iron.

### **Procedure:**

Clean joint area. Paint the alloy on all surfaces to be joined by means of a brush or spatula. If a wire is to be joined, it may be dipped into the paste. With a torch keep the flame at about 50 mm from the work and constantly in motion until the clear flux flowing to the top starts to darken. In furnace, 250° to 275°C is the best operating temperature. With solder iron, apply directly or indirectly to the area. Allow part to cool for solidification. Remove flux with a damp cloth or rinsing in hot water.

**Bonding Temperature:** 190°C.

**Tensile Strength:** 4 Kg/mm<sup>2</sup>  
(7200 psi)