WUNDER 170 FC

Solenoid Valve Piston

Flux coated brazing alloy for coating and build up application on all types of ferrous and non-ferrous metals.

Typical Applications:

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

Outstanding Features:

- Dense deposit with low coefficient of friction
- Excellent corrosion resistence.
- Highly machinable.
- Excellent control on multi-pass build-ups.
- Deposits work harden in service.
- Deposits can be given shape using flame.

Recommendation:

For build-up and overlay applications on all ferrous and non-ferrous alloys except white metals. Superior wettability of deposit 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 flux drop from end of the 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 melt & bonds properly. Air cool. Remove flux residues by washing with water. Use EWACFLUX 170 for supplementary requirements. Deposits can be flame machined using oxy-acetylene flame.

Size:

Size (mm)
2.5
3.15

Hardness: 95 HRB

Bonding Temperature: 875°C

Tensile Strength: 62 Kg/mm^2 (87,000 psi)