

Gas brazing alloys:

Brazing is a welding process, which produces coalescence of materials by heating them to a suitable temperature and by using a filler metal having melting point above 450°C. The filler metal is distributed between closely fitted surfaces of the joint by capillary action. The placement of the filler metal affects the quality of the joint. For normal lap joints, the filler metal should be supplied from one end only allowed to flow completely through the joint by capillary action.

The correct fluxing material must be used. The placement of the flux also affects the quality of the brazed joint. Paste flux is the most common from and is usually spread over the surfaces to be joined. It is also painted on the pre – placed brazing filler materials.

