

Xuper 145 XFC



GI Pipe Fittings

Flux coated brazing rod for joining all type of steel, stainless steel, cu alloy, cast iron & galvanized steel

Typical Applications:

Exhaust manifold, metal frames, car bodies, piping, flanges, cast iron housing, copper base plumbing and galvanised sheets & tubes.

Outstanding Features:

- Durable and flexible flux coating.
- Retains corrosion resistance properties after brazing on galvanized surfaces.
- No smoke, fumes; clear visibility of molten pool.
- Superior wettability.
- Can be brazed directly on contaminated surface.

Recommendation:

For joining all types of steels, stainless steels, copper alloys, cast iron and galvanised sheets. Outstanding wetting action, especially for contaminated cast iron. Ideal for dissimilar metal combinations. Flux provides double action cleansing / deoxidation without glare of molten metal or fumes.

Procedure:

Clean joint areas. Bevel heavy section. Preheat casting and heavy plates to approximately 400°C. For GI use oxidising flame for pre-heating then with neutral flame melt some flux from the end of the rod on the beginning of joint. Heat broadly till flux liquefies. Deposit alloy thereafter, making sure each drop flows and bonds properly. Air cool. Remove flux residues by washing with water. Use Xuper 145XFC flux for supplementary requirement.

Size:

Size (mm)
3.15
5.00

Bonding Temperature: 850°C

Tensile Strength: 46 kg/mm²
(65,000 psi).