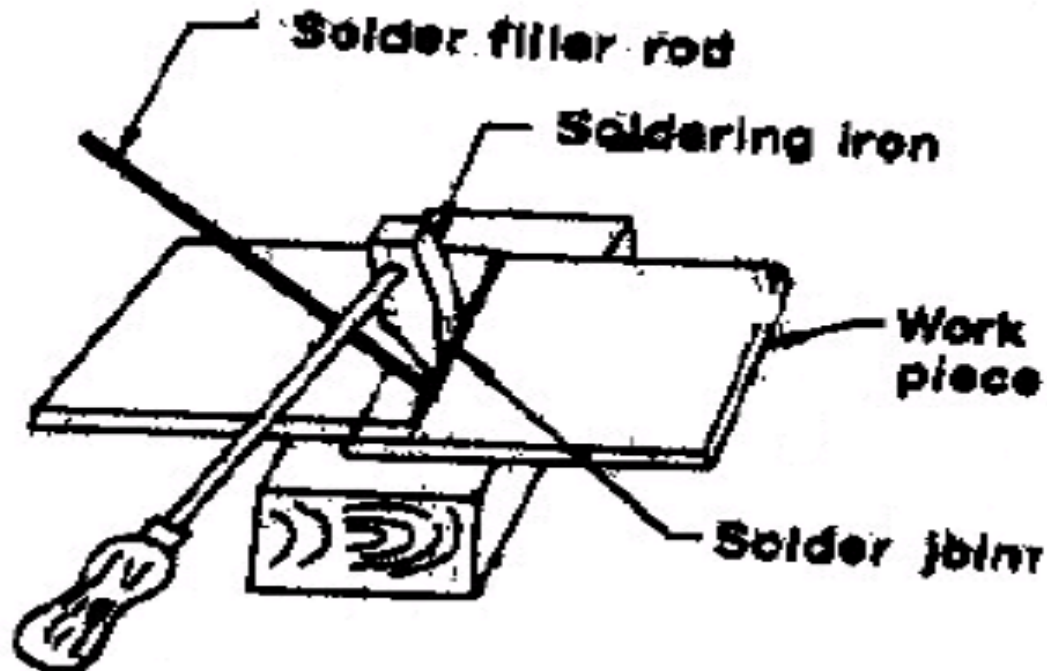


SOLDERING

The process of joining of two dissimilar metals by means of filler metal called solder is known as soldering.

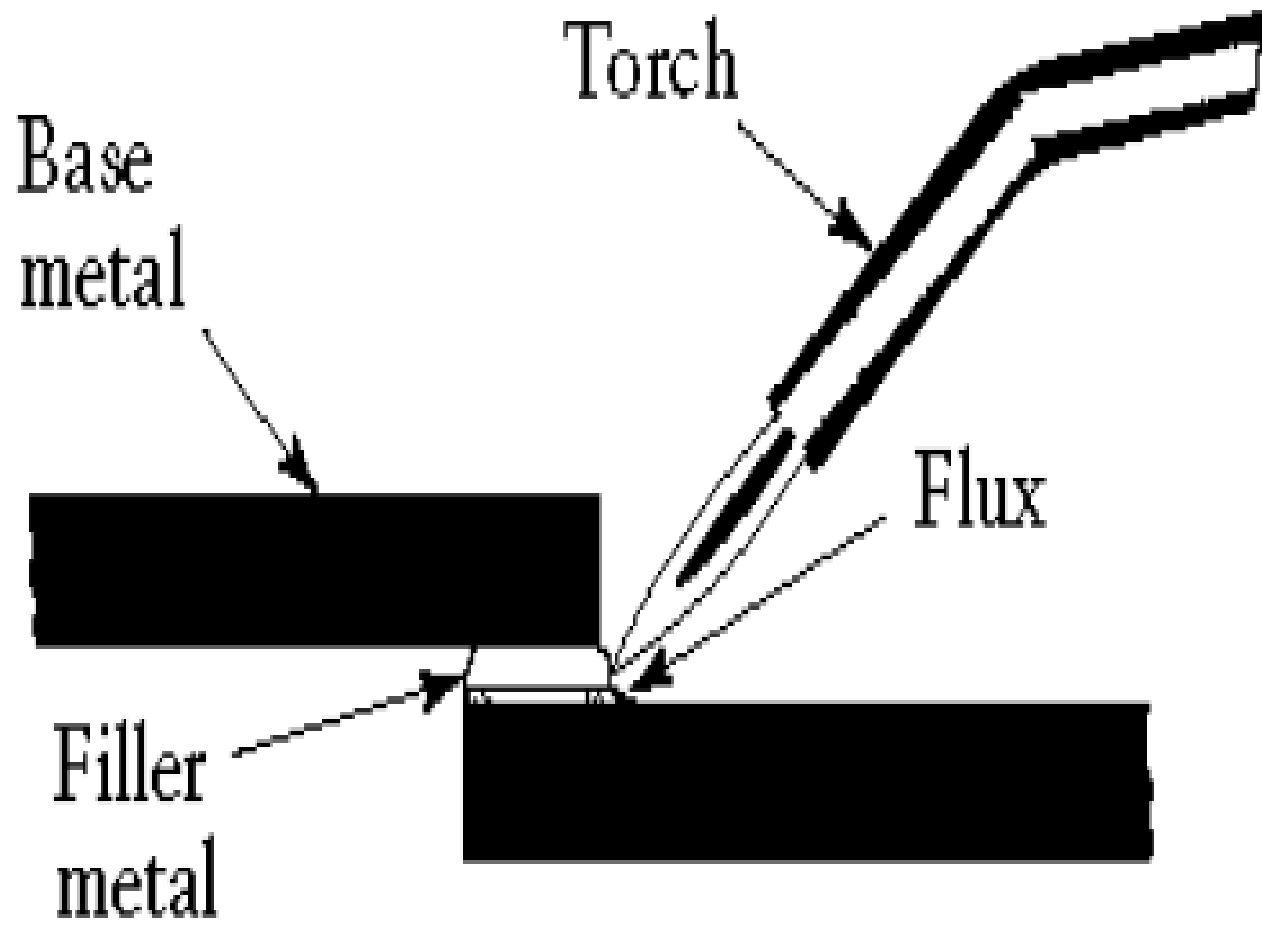
- ✓ Melting temperature is below 430°C
- ✓ Soft soldering being a low temperature 300°C



BRAZING

It is defined “ joining of two metal pieces by means a filler metal”

- ✓ Liquid temperature is above 450°C
- ✓ This filler metal in the form liquid is adhered to the base metal and the joint is made between the two work pieces.
- ✓ The fluxes are added to remove the oxides present in the filler metal then only the base metal joint is extremely cleaned
- ✓ The most commonly used fluxes are boric acid, chlorides, fluoxides for brazing the ferrous material or copper based materials used as a filler metal
- ✓ The silver is used as a filler metal for silver brazing



Advantages

- ✓ Temperature involved in this process is low
- ✓ This process is quick & clean
- ✓ Complicated shapes can be made
- ✓ Smooth surface finish can be obtained

Disadvantages

- ✓ Cost is high
- ✓ Skilled labours is required
- ✓ It is not suitable for mass production & heavy components