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The invention relates to the alloy activation processes, in particular to processes for activating the tungsten-containing hard alloys surfaces for low-temperature brazing.
The process, according to the first variant, includes the electrochemical activation of the alloy surface with an electrolyte, containing, g/l:
$NaOH$ 25…200
$NaNO_3$ 25…200

at an electric current density of 1…100 A/dm^2 and the temperature of 20…25°C.
The process, according to the second variant, includes the electrochemical thermal activation of the alloy surface with an electrolyte, containing, g/l:
NH_4Cl 100
NH_4OH 50

at the electrode voltage of 150…220V, the electric current density of 1…2 A/dm^2 and the anode temperature of 750°C.
The process, according to the third variant, includes the electrochemical thermal activation of the alloy surface with an electrolyte, containing, g/l:
NH_4Cl 110
NH_4NO_3 110

at the electrode voltage of 150…220V, the electric current density of 1…2 A/dm^2 and the anode temperature of 750°C.

Claims: 3