



A Superior Quality “Brushable” Paste
Alloy with High Silver Content and
Improved Mechanical Properties

Eutec Silweld

1618 PA

- Excellent fluidity for tight fitting or long joints
- Good color match to stainless steel
- Cadmium Free
- Easy, warm water clean-up

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EutecSilweld1618PA is a cadmium-free, high silver preplacement paste for use with most commonly used brazing processes. Because the metal component is finely ground, heat up times are greatly reduced and the activity of the carrier flux is not compromised. Suitable for use on most brasses and bronzes, cupro-nickel alloys, stainless steels and carbon steels.

TECHNICAL DATA

Typical Values	
Typical Tensile Shear Strength:	85,000 psi (585 N/mm ²)
Electrical Conductivity - IACS:	8.3%
Electrical Resistivity:	20.7 microhm-cm
Solidus Temperature ¹ :	1145°F (620°C)
Liquidus Temperature ² :	1205° F (650°C)
Maximum Brazing Temp.:	1400°F (760°C)
Heating Methods:	Oxy-fuel torch, induction, resistance heating and furnace brazing

¹ The solidus temperature is the highest temperature at which the part remains solid i.e. the start of melting.

² The liquidus temperature is the lowest temperature at which the part is molten i.e. complete melting.

PROCEDURE FOR USE

PREPARATION: Clean joint area with RotoClean® OS or use a proprietary VOC-free solvent. Thoroughly mix the paste so that the flux and metal particles are well amalgamated and show a smooth consistency. Use a fine brush or spatula to apply the paste.

TECHNIQUE: Heat insert parts slowly indirectly to reduce thermal shock so to promote uniform flow.

Note: During the melting phase it is important that the parts being brazed to not move. Observe flow indications so that all contact surfaces are seen to be brazed and flow-through is evident.

POST BRAZING: Allow parts to cool naturally. Parts can be quenched to help with flux residue removal.

TYPICAL APPLICATIONS

- Food and dairy industry
- Delicate jewelry
- Tool repairs
- Electrical contacts
- High quality plumbing and water fixtures



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