



Flux Coated Cadmium-Free
Silver Brazing Rod

EutecRod®

1028 FC

- Useful for parts with no uniform clearance
- No preparatory fluxing necessary
- Recommended for brazing stainless steel, nickel or nickel alloys where stress cracking occurs during the heating process
- Suitable for brazing thin sections or thin cracks
- Good corrosion resistance

EutecRod® 1028 FC

EutecRod 1028 FC is a low-temperature, Cadmium-free, silver brazing alloy for joining most ferrous and non-ferrous metals. Its lower melting temp makes it an ideal candidate for replacing Cadmium-bearing alloys in a variety of thin-walled joint, including applications where FDA approval is necessary.

TECHNICAL DATA

Typical Values

Solidus:	1145°F (618°C)
Liquidus:	1205°F (651°C)
Brazing Range:	1205 - 1400°F (651 - 760°C)
Electrical Conductivity:	11.9% IACS
Electrical Resistivity:	14.5 Michroh-m-cm
For Joint Clearances:	.001 to .005 inches
Max. Operating Temp.:	400°F (204°C) continuous service 600°F (315°C) intermittent service

**International Annealed Copper Standard*

***Resistance based on uniform Length and Cross-section*

PROCEDURE FOR USE

PREPARATION: The base metal surfaces to be brazed must be clean and free of all dirt, oil, grease and oxides such as rust.

FINISHING: All the corrosive flux residue must be removed after brazing. Rinse with water while the parts are still warm, or rinse with hot water.

AVAILABILITY: Available in 18" lengths in 3/64", 1/16" and 3/32" diameters. Packaged in 0.5 lb., 1 lb., 2 lb. and 5.5 lb. packs.

TYPICAL APPLICATIONS

Suitable for brazing thin sections of fabricated steel boxes, butt joints, fixtures, brass wave guides, brass/copper radiator repair, heat exchangers (thin cracks) and valves.



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