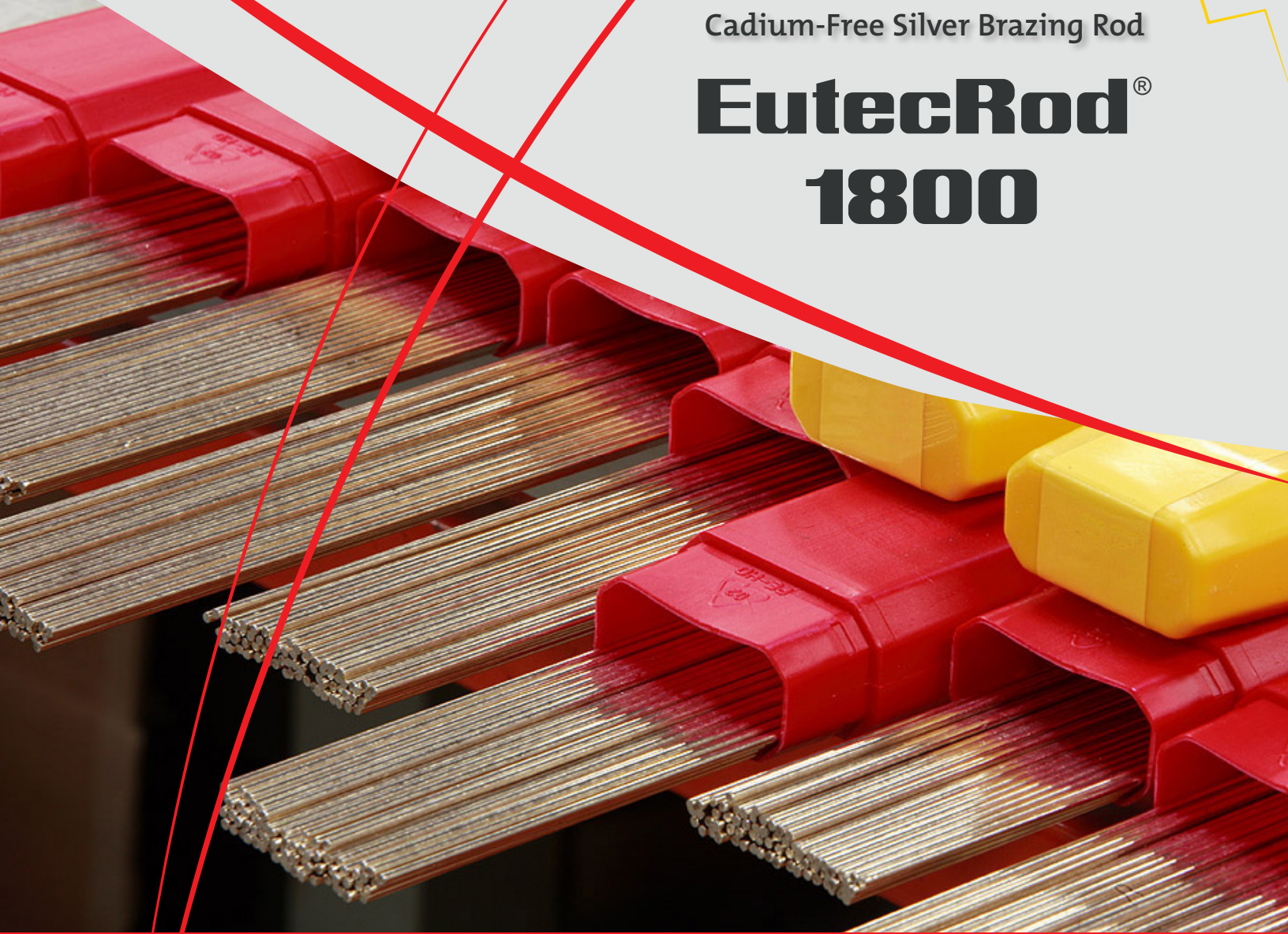




Cadium-Free Silver Brazing Rod

EutecRod®

1800



- Good corrosion resistance
- Excellent Fluidity for joint clearances of .001 - .005 inches
- Good color match to silver and stainless steel
- Suitable for use on steel, stainless steel, copper, nickel and most combinations thereof

EutecRod® 1800

EutecRod 1800 is a cadmium-free flux silver brazing alloy filler metal rod that has the lowest brazing temperature, best wetting, and best flow of all the cadmium-free brazing alloys. Its low zinc content minimizes problems due to excessive heating - by less skilled operators. With EutecRod 1800 no preparatory fluxing is necessary and its specially formulated with extremely flexible anti-glare flux coating that is ideal for difficult to reach applications.

EutecRod 1800 is suitable for use with most iron, nickel, and copper based alloys. It is especially recommended where stress-cracking during heating is a concern or a color match to silver or stainless is necessary.

Generally, the joint strength post-weld of EutecRod 1800 will exceed the strengths of the base metals being joined. Type of joint, design of joint, joint clearances, and brazing procedures will effect the finished joint strength.

EutecRod 1800 has excellent fluidity for joint clearances of .001 - .005 inches and exhibits good corrosion resistance.

TECHNICAL DATA

Typical Values

Solidus:	1145°F (618°C)
Liquidus:	1205°F (651°C)
Brazing Range:	1205 - 1400°F (651 - 760°C)
Specific Gravity:	9.49
Density:	4.96 oz/cu. in.
Electrical Conductivity:	8.6% IACS*
Electrical Resistivity:	20.7 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 metal surfaces to be joined must be clean and free of all dirt, oil, grease and oxides. RotoClean or other VOC-Free solvent is recommended for the best results. Polished surfaces should be roughened and Copper alloys preheated according to their grade.

FINISHING: Apply XuperBraz 100 or comparable fluxing product to the joint. Use a 2x carburizing flame to prevent oxidation. After ehatng, deposit filler using a continuous 'drop-and-melt' technique until joint is slightly overfilled.

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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