



Flux Coated Cadmium-Free
Silver Brazing Rod

Xuper® **1020 XFC**

- Anti-glare flux coating, easy on the eyes
- Extremely flexible flux coating for difficult to reach applications
- Low zinc content minimizes problems due to excessive heating
- No preparatory fluxing necessary
- Excellent fluidity for joint clearances of .001 - .005 inches
- Suitable for brazing thin sections or thin cracks
- Often used with silver or stainless steel due to its color match

Xuper® 1020 XFC

Xuper 1020 XFC is a cadmium-free flux coated 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 Xuper 1020 XFC no preparatory fluxing is necessary and its specially formulated with extremely flexible anti-glare flux coating that is ideal for difficult to reach applications.

Xuper 1020 XFC is recommended for brazing stainless steel, nickel or nickel alloys where stress cracking occurs during the heating process. Its suitable for use on steel, stainless steel, copper, copper alloys, nickel, nickel alloys or a combination. It is often used with silver or stainless steel due to its color match.

Generally the joint strength post-braze of Xuper 1020 XFC 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.

Xuper 1020 XFC has excellent fluidity for joint clearances of .001 - .005 inches and exhibits good corrosion resistance.

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 warm, or rinse with hot water.

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

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/in ³
Electrical Conductivity:	11.9% IACS
Electrical Resistivity:	14.5 Microhm-cm
Color, as Brazed:	Light Silver
For Joint Clearances:	.001 to .005 inches
Max. Operating Temp.:	400°F (204°C) continuous service 600°F (315°C) intermittent service
Flux Color:	Pink

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), valves, etc.



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



Follow Us On...

