



Flux Coated Cadmium-Free  
Silver Brazing Rod

# **EutecRod®**

## **1020 FC**

- Anti-glare flux coating, easy on the eyes
- 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

# EutecRod® 1020 FC

EutecRod 1020 FC 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 EutecRod 1020 FC no preparatory fluxing is necessary.

EutecRod 1020 FC 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-weld of 1020 FC 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 1020 FC has excellent fluidity for joint clearances of .001 - 0.005 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 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.

## TECHNICAL DATA

### Typical Values

<b>Solidus:</b>	1145°F (618°C)
<b>Liquidus:</b>	1205°F (651°C)
<b>Brazing Range:</b>	1205 - 1400°F (651 - 760°C)
<b>Specific Gravity:</b>	9.49
<b>Density:</b>	4.96 oz/cu. in.
<b>Electrical Conductivity:</b>	11.9% IACS
<b>Electrical Resistivity:</b>	14.5 Michroh-m-cm
<b>Color, as Brazed:</b>	Light Silver
<b>For Joint Clearances:</b>	.001 to .005 inches
<b>Max. Operating Temp.:</b>	400°F (204°C) continuous service 600°F (315°C) intermittent service
<b>Flux Color:</b>	White

## 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.



**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...

