



Flux Coated Cadmium-Free
Silver Brazing Rod

Xuper®

1630 XFC

- Excellent general purpose, intermediate temperature brazing alloy
- Useful for parts with no uniform clearance
- No preparatory fluxing necessary
- Extremely flexible flux coating for difficult to reach applications
- Suitable for brazing brasses, bronze and steels
- Good corrosion resistance

Xuper® 1630 XFC

Xuper 1630 XFC 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.

TECHNICAL DATA

Typical Values

Solidus:	1250°F (677°C)
Liquidus:	1410°F (766°C)
Brazing Range:	1410 - 1575°F (766 - 857°C)
Specific Gravity:	8.85
Density:	4.66 oz/in ³
Electrical Conductivity:	24.4% IACS
Electrical Resistivity:	14.5 Microhm-cm
Color, as Brazed:	Light Yellow
For Joint Clearances:	.003 to .007 inches

The recommended maximum operating temperature of Xuper 1630 XFC is up to 400°F (204°C) in continued service and up to 600°F (316°C) in intermittent service.

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.

TYPICAL APPLICATIONS

A good general purpose brazing rod with excellent flow on brasses, bronzes, and ferrous base metals. Useful in bridging gaps where poor joint fitups cannot be avoided and where brazed assemblies come into contact with food or dairy products.



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