



Flux Coated Cadmium-Free
Silver Brazing Rod

Xuper®

1665 XFC

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

Xuper® 1665 XFC

Xuper 1665 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:	1200°F (649°C)
Liquidus:	1310°F (710°C)
Brazing Range:	1310 - 1550°F (710 - 843°C)
Specific Gravity:	9.03
Density:	4.76 oz/in ³
Electrical Conductivity:	18.0% IACS
Electrical Resistivity:	9.60 Microhm-cm
Color, as Brazed:	Pale Yellow
For Joint Clearances:	.001 to .005 inches

The recommended maximum operating temperature of Xuper 1665 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 20" length and 1/16" (1.6 mm) diameter.

TYPICAL APPLICATIONS

A good general purpose brazing rod with excellent flow on brasses, bronzes, and ferrous base metals.



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