

Nickel Enhanced, Copper-Base, Brazing Rod for Tough Re-Builds and
Low Frictional Overlays

Xuper[®] 18 XFC



BRAZING

- Controlled Nickel content for improved mechanical properties
- Low-fuming rod for Welder friendly use
- Good resistance to grinding wear



DESCRIPTION:

A yellow colored flexible flux coated brazing rod. Available in 18" lengths in 1/8" diameter 11 lb. packs and 3/16" diameter 11 lb. packs.

TECHNICAL DATA:

Tensile Strength: 65,000 psi, average

Elongation, in² in.: 25%

Brinell Hardness: 92

Solidus: 1665°F / 907°C

Liquidus: 1680°F / 916°C

Brazing Range: 1720°F - 1800°F / 938°C - 982°C

Specific Gravity: 8.19

Density (lb/cu in): .295

Color, as Brazed: Yellow

SPECIFICATION:

1. AWS A5.8 Class RBCuZn-B
2. ASME SFA5.8 Class RBCuZn-B
3. QQ-R-571C
4. MIL-R-19631B

TYPICAL APPLICATIONS:

For brazing steel, cast iron, galvanized sheet, and cast bronze and brass. Building up wear surfaces and bearings.

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.

Post-brazing: All the corrosive flux residue must be removed after brazing. Rinse with water while the parts are still warm, or rinse with hot water.

HEALTH AND SAFETY:

Observe normal brazing and welding practices, respiratory protection and proper air flow pattern advised. For general welding and brazing practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding and brazing are completely safe processes when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding or brazing operations. DO NOT operate brazing or welding equipment or use brazing and welding materials before you have thoroughly read the proper instruction manual(s).

Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information.

DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF BRAZING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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