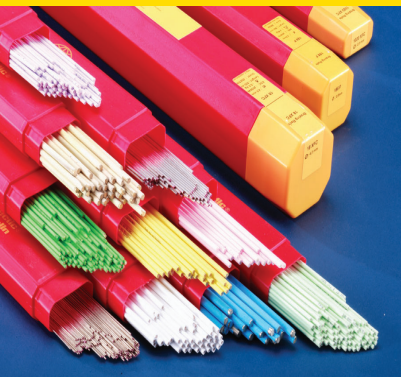


Tin-Silver Brazing Rod for Stainless Steels, Brass, Bronze and Nickel Alloys

EutecRod[®] 157



BRAZING

- All-purpose Cadmium-free, Lead-free solder
- Best balance of mechanical properties with low-temperature application
- Good corrosion resistance and electrical conductivity
- Excellent color match to stainless steels



DESCRIPTION:

EutecRod 157 rod soldering alloy is particularly suitable for stainless steel assemblies, brass and bronze components, nickel alloys, and most carbon steels when used with Eutectic Flux 157. Deposits are corrosion resistant and do not tarnish in service.

TECHNICAL DATA:

Tensile Strength: 15,000 psi (105 N/mm²)
Thermal Expansion Coef.: 12×10^{-6} in/ °F (20-212°F)
Working Temperature¹: 430°F (220°C)
Max Brazing Temp: 450°F (230°C)
Elec. Conductivity: 16.5 IACS
Heating Methods: Oxy-fuel torch, induction, resistance heating and furnace soldering

¹ The solidus temperature is the highest temperature at which the part remains solid i.e. the start of melting.

² The liquidus temperature is the lowest temperature at which the part is molten i.e. complete melting.

WELDING PARAMETERS:

Preparation: Clean joint area with RotoClean OS or use a proprietary VOC-free solvent. For best results apply EutecTor 157 Flux to the joint prior to fit-up.

Note: For best results maintain joint clearances between 0.001" and 0.005".

Technique: Heat insert parts slowly and indirectly to reduce thermal shock to promote uniform flow. When flux begins to bubble, apply solder.

Post-brazing: Thoroughly clean all flux residue with a wire brush and warm water. Allow parts to cool naturally. Parts can be quenched to help with flux residue removal.

Flux will become corrosive if not removed prior to putting part in service.

TYPICAL APPLICATIONS:

For soldering dairy utensils, food-handling equipment, plumbing fixtures and potable water containers and piping. Also useful for joining electrical connectors*.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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