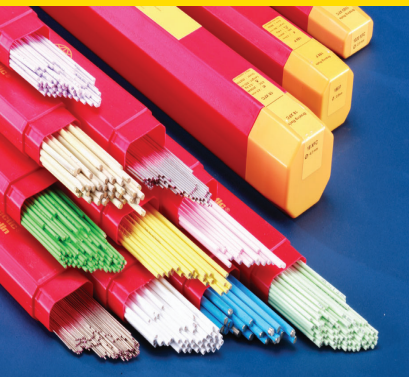


Cadium-Free Silver Brazing Rod, Coil and Strip

EutecRod[®] 1801 G



BRAZING

- A cadmium-free silver brazing alloy filler metal available in bare rod, coil or strip
- An excellent general purpose brazing alloy that is often associated as the ideal replacement for many of the cadmium bearing alloys
- It is suitable for joining ferrous, nonferrous and dissimilar base metals with close joint clearances
- Excellent fluidity for joint clearances of .002 - .006 inches



DESCRIPTION:

EutrcRod 1801 G is an excellent general purpose brazing alloy that is often associated as the ideal replacement for many of the cadmium bearing alloys. 1801 G is suitable for joining ferrous, nonferrous and dissimilar base metals with close joint clearances.

Generally, the joint strength using 1801 G 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.

1801 G is available in bare brazing rod, coil or strip requiring preparatory fluxing with XuperBraz® 100.

TECHNICAL DATA:

Solidus:	1195°F
Liquidus:	1250°F
Brazing Range:	1260°F - 1500°F
Specific Gravity:	9.11
Density:	4.8 oz/cu.in.
Electrical Conductivity:	19.0 % IACS
Electrical Resistivity:	9.08 Michroh-m-cm
Color, as Brazed:	Yellow White
For Joint Clearances:	.002 to .006 inches

BRAZING PROCEDURE:

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.

TYPICAL APPLICATIONS:

- Food and dairy industry
- Electrical industry
- Brass parts / piping
- Aircraft engine coolers

AVAILABILITY:

ROD:

Length: 18"
Diameters: 1/16" (1.6mm), 3/32" (2.4mm)
Wt.: 0.5lb, 1 lb, 2 lb and 5 lb packs

COIL:

Diameters: 0.30"
Wt.: 1 lb pack

STRIP:

Size: 0.005" x 1", 0.020" x 1.5"
Wt.: 1 lb and 10 lb packs

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



EUTECTIC CORPORATION
N94 W14355 Garwin Mace Drive
Menomonee Falls, WI 53051 USA
Tel.: +1 (800) 558-8524
eutectic.com

EUTECTIC CANADA
428, rue Aimé-Vincent
Vaudreuil-Dorion, Québec
J7V 5V5 Canada
Tel.: +1 (800) 361-9439
eutectic.ca



Statement of Liability: Due to variations inherent in specific applications, the technical information contained herein, including any information as to suggested product applications or results, is presented without representation or warranty, expressed or implied. Without limitation, there are no warranties of merchantability or of fitness for a particular purpose. Each process and application must be fully evaluated by the user in all respects, including suitability, compliance with applicable law and non-infringement of the rights of others, and Eutectic Corporation and its affiliates shall have no liability in respect thereof.

1801G 06/17 © 2008, Eutectic Corporation, ® Reg. T.M., Printed in the U.S.A.