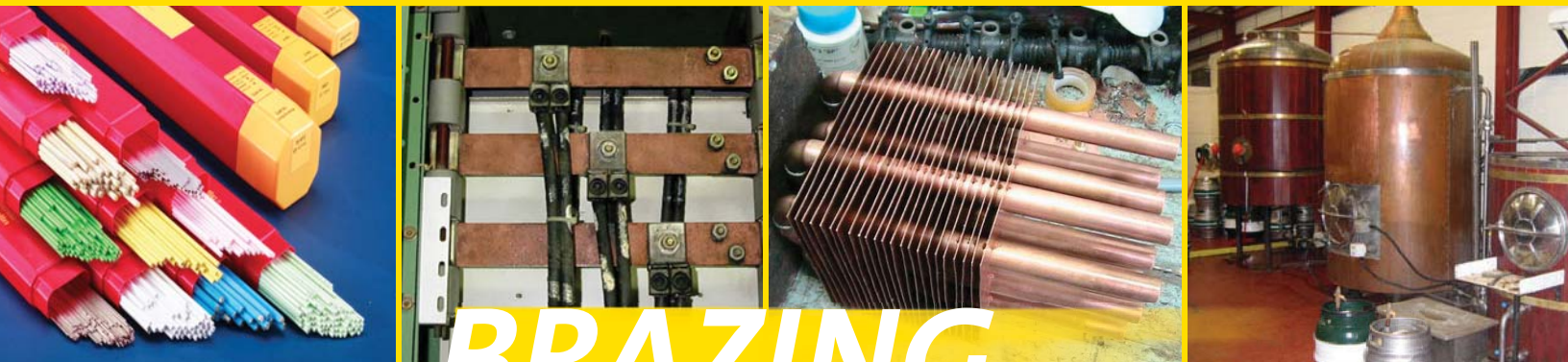


Low Heat, Self-Fluxing Copper-Base Alloy

EutecRod[®] 180



BRAZING

- High wettability and fluidity
- Low melting point
- Excellent joint electrical conductivity
- Strong, ductile, leak-proof joints
- Good corrosion resistance
- Designed for brazing copper and copper alloys



DESCRIPTION:

EutecRod 180 is a high strength, silver-free alloy for thin flowing application on thin-walled and intricate copper and copper alloy parts.

Excellent for use on lap, tee, square butt and flange joints, thin and dissimilar gauges. Self-fluxing on copper. Not suitable for nickel or ferrous alloys. Proprietary EutectoFilm® metallic cladding on EutecRod 180 insures an ultra clean surface completely devoid of oxide, which enhances flow characteristics.

EutecRod 180 is designed for brazing copper and copper alloys.

TECHNICAL DATA:

Typical Tensile Shear Strength: 42,000 psi 290 N/mm²
Electrical Conductivity: IACS 22%
Electrical Resistivity: 7.9 microhm-cm
Solidus Temp¹: 1310°F (710°C)
Liquidus Temp²: 1460°F (795°C)
Max.Brazing Temp.: 1550°F (845°C)
Heating Methods: Oxy-fuel torch, induction,
furnace brazing

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.

BRAZE WELDING PROCEDURE:

Preparation: Clean joint area with RotoClean® OS or use a proprietary VOC-free solvent. Align parts and preheat locally to facilitate quicker joint area heat-up. When brazing copper to brass or bronze paint joint area and rod with FloTectic® Flux 1100.

Technique: Use a 2x carburizing flame to prevent oxidation. After preheating, deposit filler metal using a continuous “drop-and-melt” technique.

Note 1: EutecRod 180 is very fluid. Make sure joint gaps do not exceed 0.005”. Continue until the joint is slightly overfilled.

Note 2: When using a flux any “glassy” residue can be readily removed by light scraping.

Post-brazing: If necessary, parts can be cooled in water.

TYPICAL APPLICATIONS:

Air-Conditioning Equipment	Heaters
Armatures	Heat Exchangers
Bottling Equipment	Motors
Brewery Equipment	Plumbing
Bus Bars	Radiators
Cooling Coils	Railroad Equipment
Electrical Connections	Refrigeration Equipment
Flexible Tubing	Water Cooler Wiring
Generators	

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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