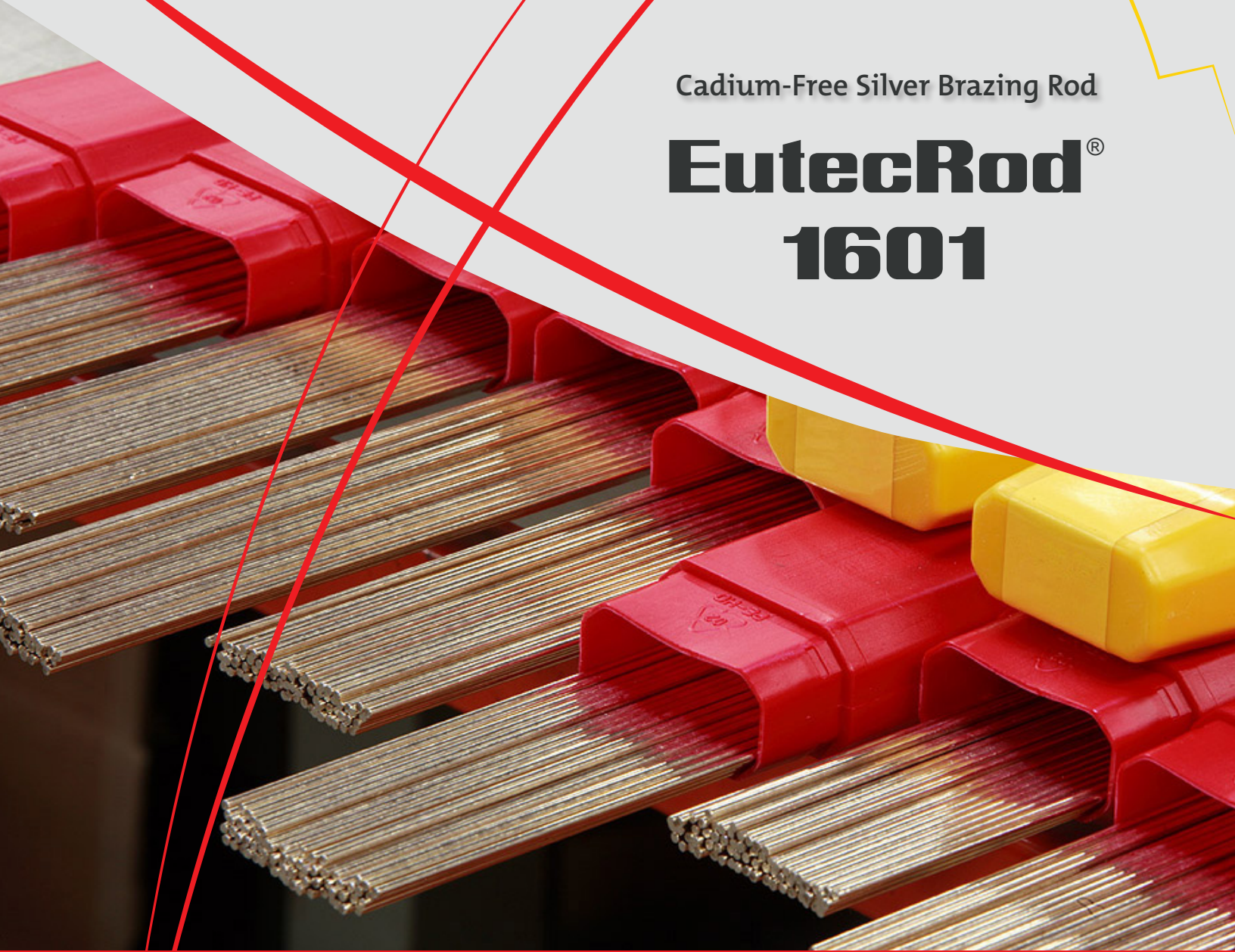




Cadmium-Free Silver Brazing Rod

EutecRod®

1601



- Cadmium - free bare rod general purpose brazing alloy
- Widely used on joints where greater corrosion resistance is needed
- It exhibits good wetting action and flow
- Useful in bridging gaps where poor joint fitups cannot be avoided
- Excellent corrosion resistance
- Joint clearances of .003 - .008 inches recommended for proper capillary action

EutecRod® 1601

A bare brazing rod requiring preparatory fluxing with XuperBraz 100 or Xuper Braze 100H. Available in 18" lengths in 1/16" diameter. Packaged in 0.5 lb. and 1 lb. packs.

TECHNICAL DATA

Typical Values

Solidus:	1220°F (660°C)
Liquidus:	1435°F (779°C)
Brazing Range:	1435 - 1585°F (779 - 863°C)
Specific Gravity:	9.04
Density:	4.76 oz/in ³
Electrical Conductivity:	16.8% IACS
Electrical Resistivity:	10.27 Microhm-cm
Color, as Brazed:	Light Yellow
For Joint Clear:	.003 to .008 inches

The recommended maximum operating temperature of 1601 is up to 400°F in continued service and up to 600°F 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 still warm, or rinse with hot water.

SPECIFICATION: Generally, the joint strength using 1601 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.

TYPICAL APPLICATIONS

Suitable for brazing tungsten carbide inserts, general tool tipping, and stainless steel food containers and food handling equipment. Used where greater corrosion resistance is required.



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