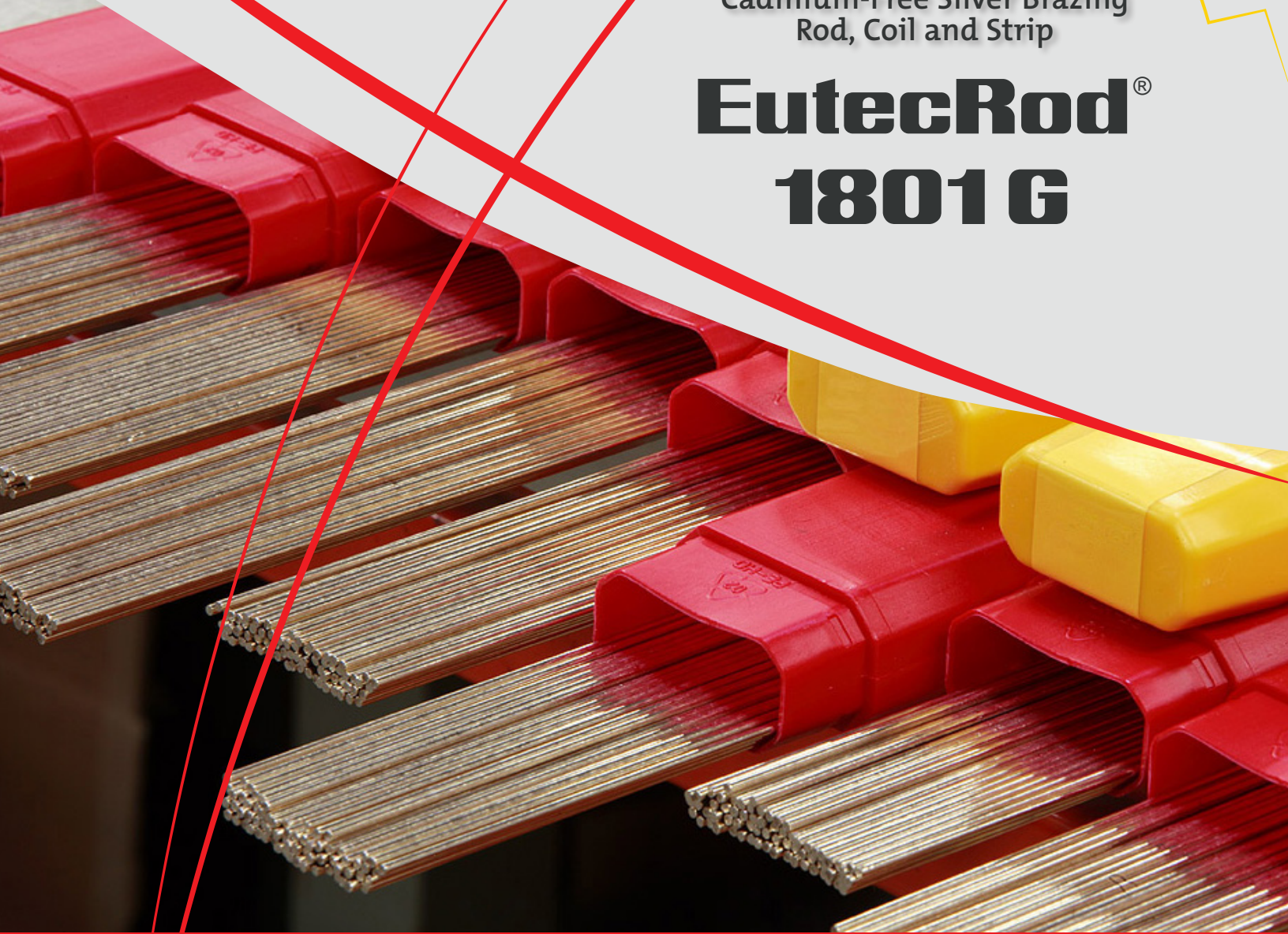




Cadmium-Free Silver Brazing
Rod, Coil and Strip

EutecRod®

1801 G



- A cadmium- free silver brazing alloy filler metal available in bare rod, coil or strip
- General purpose brazing alloy, ideal replacement for cadmium bearing alloys
- Suitable for close-joint joining of ferrous, nonferrous and dissimilar base metals
- Excellent fluidity for joint clearances of .002 - .006 inches

EutecRod® 1801 G

EutecRod 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

Typical Values

Solidus:	1195°F (646°C)
Liquidus:	1250°F (677°C)
Brazing Range:	1260 - 1500°F (682 - 816°C)
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:	.001 to .005 inches

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.

AVAILABILITY:

ROD:

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

COIL:

Diameters: 0.30"
Weight: 1 lb pack

STRIP:

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

TYPICAL APPLICATIONS

- Food and Dairy Industry
- Electrical Industry
- Brass Parts / Piping
- Aircraft Engine Coolers



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



Follow Us On...

