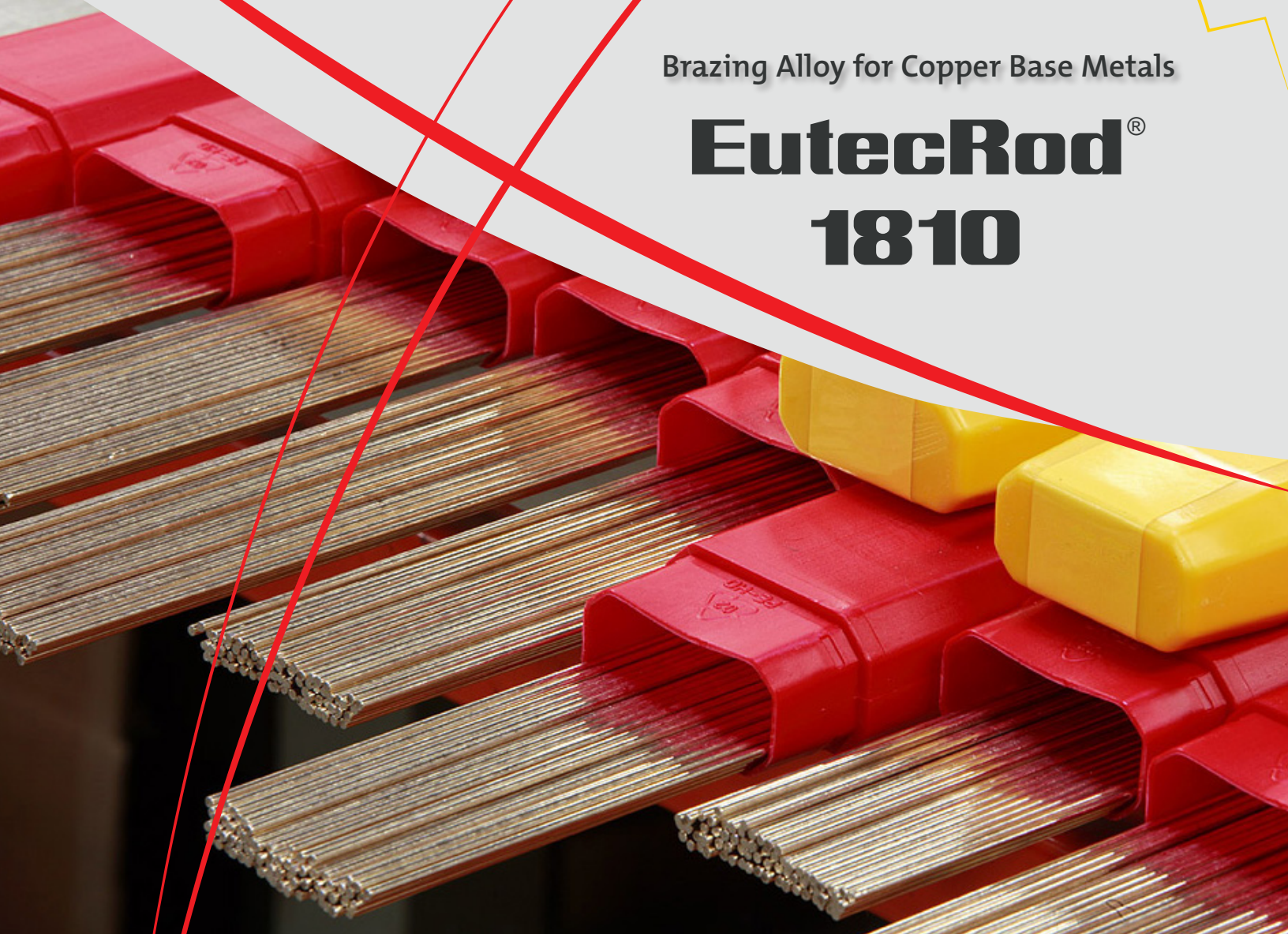




Brazing Alloy for Copper Base Metals

EutecRod®

1810



- Good for most brasses, bronzes and ferrous base metals
- Economical free-flowing brazing alloy
- It's bridging properties make it ideal for poor fit-up joints

EutecRod® 1810

EutecRod 1810 is a cadmium-bearing silver alloy for use with most commonly used brazing processes. Its bridging properties make it suitable for poor fit-up joints. Formulated for use on most brasses, bronzes and ferrous base metals and dissimilar metal joining of thin-gauge materials.

TECHNICAL DATA

Typical Values

Tensile Shear Strength:	58,000 psi (400 N/mm ²)
Solidus*:	1125°F (607°C)
Liquidus**:	1310°F (710°C)
Max. Brazing Temp.:	1500°F (815°C)
Electrical Conductivity:	15% IACS
Electrical Resistivity:	11 Microhm-cm
Heating Method:	Oxy-fuel torch, induction & furnace brazing

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

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

PROCEDURE FOR USE

PREPARATION: Clean joint area with RotoClean OS or use a VOC-free solvent. Lightly roughen highly polished stainless steel to promote quicker bonding. Align parts and preheat copper-base alloys locally to facilitate quicker joint area heat-up.

Note: Preheating copper-base alloys depending upon the type and grade.

TECHNIQUE: Use a 2x carburizing flame to prevent oxidation, important when brazing stainless steels. Braze rapidly and avoid overheating. After preheating, deposit filler metal using a continuous “drop-and-melt” technique. Continue until the joint is slightly overfilled.

Note: When additional fluxing is called for, use Wonder Flux or XuperBraz 100.

POST-BRAZING: If necessary, parts can be cooled in water.

TYPICAL APPLICATIONS

EutecRod 1810 is an economical alloy for repairing musical instruments, medical equipment brazing, general hospital equipment repairs, fitment brazing of tool & dies, evaporators and bell and retort pipe fittings.



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