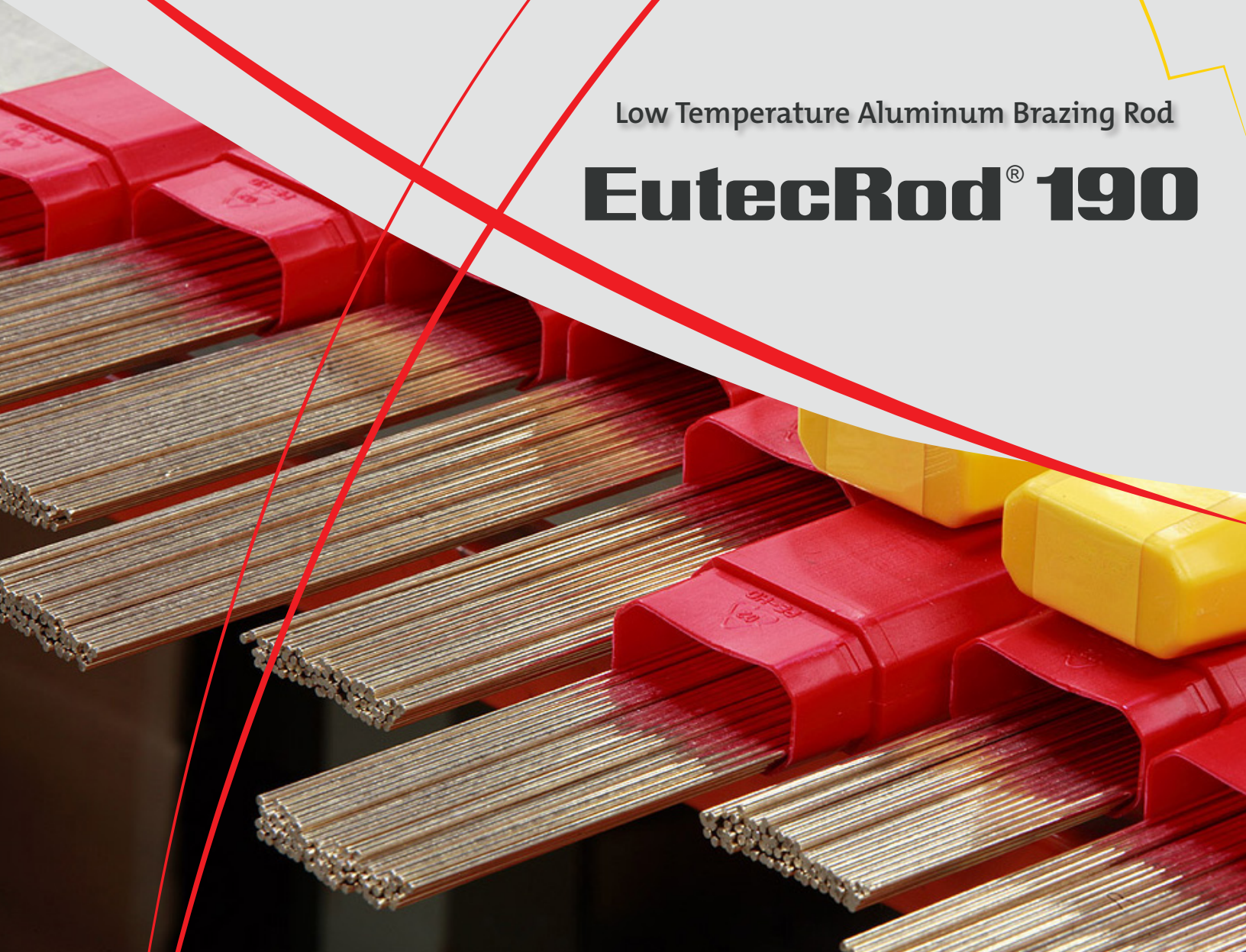




Low Temperature Aluminum Brazing Rod

# **EutecRod® 190**



- Perfect for high strength joining of aluminum tee and lap joints
- High strength fillet and bead joints on sheet, extruded and cast aluminum
- Excellent bridging properties for poor fit joints
- Aluminum joining without melting base metal

# EutecRod® 190

EutecRod 190 provides exceptional thin-flowing properties with oxy-fuel brazing sheet, tubing and most wrought forms of aluminum. Excellent color match with smooth, uniform fillets. Properties are highly compatible with aluminum grades 3xxx & 4xxx.

## TECHNICAL DATA

### Typical Values

|                                    |   |
|------------------------------------|---|
| <b>Tensile Shear Strength:</b>     | 34,000 psi (234 N/mm <sup>2</sup> )                   |
| <b>Electrical Conductivity:</b>    | 42% IACS  |
| <b>Solidus Temp.<sup>1:</sup></b>  | 1070°F (575°C)  |
| <b>Liquidus Temp.<sup>2:</sup></b> | 1080°F (580°C)  |
| <b>Max. Brazing Temp.:</b>         | 1120°F (605°C)  |
| <b>Heating Methods:</b>            | Oxy-fuel, resistance, induction                       |
| <b>Color Match Properties:</b>     | Similar to wrought aluminum (will darken if anodized) |

<sup>1</sup> The solidus temperature is the highest temperature at which the part remains solid i.e. the start of melting.

<sup>2</sup> The liquidus temperature is the lowest temperature at which the part is molten i.e. complete melting.

## PROCEDURE FOR USE

**PREPARATION:** Clean joint area and lightly abrade using a stainless steel wire brush or wire wool. For best results a slight gap of between .005" and .010" is recommended. No preheat is necessary with thin gauge material. For thicknesses up to 1/8" a nominal broad preheat of 200°F (93°C) is suggested. EutecTor® 190 flux can be applied to the joint by making a paste with a small amount of water or alcohol.

*Note: EutecRod 190 requires the use of EutecTor® 190 flux.*

**TECHNIQUE:** Adjust the oxy-fuel flame so that it is slightly reducing or carburizing. Keep the torch moving rapidly to prevent localized overheating with the inner flame cone 1" to 2" from the joint. When the flux becomes molten apply the brazing alloy at equal points along the joint seam. Cool slowly.

**POST-BRAZING:** Remove flux, scrubbing in hot water and rinse.

*Note: It is mandatory to remove all traces of flux residues. If these are not removed they will cause corrosion.*

## TYPICAL APPLICATIONS

- Automotive and Bus Bodies
- Light-Gauge Truck Bodies
- Aluminum Housings
- Irrigation Piping
- Farming Implements
- Office Furniture
- Refrigeration Equipment
- Air-Conditioning Equipment



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