



High Strength Aluminum Brazing Rod

EutecRod®

21FC-E

- Rapid solidification rate for butt and beveled butt 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® 21FC-E

EutecRod 21FC-E is an extruded flux-coated brazing alloy that gives excellent performance in a variety of aluminum joining applications.

TECHNICAL DATA

Typical Values	
Tensile Shear Strength:	33,000 psi, average
Elongation, in ² :	25%
Brinell Hardness:	92
Solidus:	1090°F (588°C)
Liquidus:	1170°F (632°C)
Brazing Range:	1120 - 1190°F (604 - 643°C)
Base Metals:	1xxx, 3xxx, 4xxx, and commonly used 5xxx and 6xxx grades. For wrought and cast aluminum as well as aluminum alloys.
Equipment:	Oxy-Acetylene torch
Sizes Available:	3/32" x 18" 1/8" x 18"

PROCEDURE FOR USE

Thoroughly clean joint area. Pieces heavier than 1/8", butt joints, broken sections or cracks should be beveled to 60° - 80° vee. (not necessary for thinner sections). Leave a 1/16" to 1/8" gap and maintain alignment of parts.

Adjust oxy-acetylene torch for a slightly excess acetylene flame. Maintain a distance of 1" to 3" between flame cone and the base metal and begin preheating.

Melt a drop of flux off the end of the rod onto the beginning of the joint area. Continue heating, keeping the torch in constant motion until the flux liquefies. This is a signal that the proper brazing temperature has been reached.

With the flame cone now approximately 1/2" to 1" from the base metal, deposit a drop of alloy, placing the flame on it until it flows out and bonds. Continue depositing more alloy. Use a bead forming technique.

Care should be taken not to melt the base metal. EutecRod 21 FC-E's melting temperature is lower than aluminum. This EutecRod does not require melting of the base metal.

For very best results, use with supplemental EutecTor® Flux 21-X.

After the joint is completed, remove flux residues by washing in warm water. For optimum results, use Eutectic Pre/Post Cleaner 1002.

TYPICAL APPLICATIONS

- Elbows
- Cookware
- Oil Pan
- Frames
- Furniture
- Casting Molds
- Aluminum Housings
- Transmission Housings
- "Trash" Pumps



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