



For Oxy-Fuel Braze Welding
Broken and Fractured Gray and
Medium-Strength Alloyed Cast Irons

Xuper®

146 XFC

- Recommended for use on cast iron where color matching isn't important
- Highly active flux promotes ease of wetting and excellent bonding
- Deposits are easily machined or drilled

Xuper® 146 XFC

Xuper 146 XFC is a copper-base, flux-coated brazing rod for repairing cracks and buildup repairs of cast irons when color matching is not important and when easily machined and drilled deposits are required. The highly active flux promotes ease of wetting and excellent bonding.

TECHNICAL DATA

Typical Values

Tensile Strength:	65,000 psi (450 N/mm ²)
Hardness:	80 HRB
Color Match Properties:	Deposits are brass-yellow
Bonding Temperature:	1600 - 1650°F (871 - 899°C)
Preheating:	500 - 700°F (260 - 371°C)

PROCEDURE FOR USE

PREPARATION: Clean joint and/or broken parts. Bevel cracks either by pneumatic chiseling or by grinding.

Note: When grinding make sure not to “color” the surface that indicates overheating and potential hard-spotting. Align parts and preheat within the recommended 500 - 700°F (260 - 371°C) temperature range.

TECHNIQUE: Rapidly sear the joint by using an excess oxygen flame. Apply a small amount of EutecTor 16D as a supplemental flux along the joint area and lightly “tin” the surfaces to be joined using a neutral flame. After tinning apply filler metal using a continuous “drop-and-melt” technique. Continue until the joint is slightly overfilled.

Note: Any excess “glassy” flux residue can be readily removed by light scraping.

POST-BRAZING: Allow the brazed casting to slow-cool either by covering in vermiculite, wrapping in a heat-retardant blanket, or by burying in lime.

TYPICAL APPLICATIONS

Although formulated for cast iron components such as cast iron brackets, end-flanges, malleable piping and agricultural implements, Xuper 146 XFC is also recommended for car body repairs, light tubular constructions, and sheet metal fabrications.



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



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