



Flux Coated, Nickel-Silver,
Low Fuming Brazing Rod

Xuper® 16 XFC

- No preparatory fluxing required
- Excellent replacement for expensive silver brazing alloys
- Easily machinable
- Excellent corrosion resistance
- Joins base metals at lower temperatures than gas or arc welding
- Minimizes thermal stress and distortion with less cracking
- High strength fillets

Xuper® 16 XFC

Xuper 16 XFC is a nickel-containing flexible flux coated bronze brazing rod. 16 XFC is pre-flux coated with the correct amount of flux so there is no preparatory fluxing required.

Xuper 16 XFC is an excellent replacement for high cost silver brazing alloys when higher brazing temperatures are acceptable.

16 XFC is a blue colored flexible flux coated brazing rod. Available in 18" lengths in 1/8" diameter 11 lb. packs and 3/32" diameter 11 lb. packs.

TECHNICAL DATA

Typical Values

| | |
|----------------------------------|-----------------------------|
| Tensile Strength: | 70,000 psi, average |
| Elongation, in ² in.: | 25% |
| Brinell Hardness: | 120 |
| Solidus: | 1665°F (907°C) |
| Liquidus: | 1680°F (916°C) |
| Brazing Range: | 1720 - 1800°F (938 - 982°C) |
| Specific Gravity: | 8.47 |
| Density (lb/in ³): | 302 |
| Electrical Conductivity: | 5.5% IACS |
| Electrical Resistivity: | 31.4 Microhm-cm |
| Color, as Brazed: | Blue |
| 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 warm, or rinse with hot water.

TYPICAL APPLICATIONS

For brazing tungsten carbide, carbon steels, nickel alloys, and cast iron. Building-up overlaying worn parts as gear teeth, bearings and valve seats. Suitable for tubular structures.



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