



Nickel Enhanced, Copper-Base,
Brazing Rod for Tough Re-Builds
and Low Frictional Overlays

Xuper® 18 XFC

- Controlled Nickel content for improved mechanical properties
- Low-fuming rod for Welder friendly use
- Good resistance to grinding wear

Xuper® 18 XFC

A yellow colored flexible flux coated brazing rod. Available in 18" lengths in 1/8" diameter 11 lb. packs and 3/16" diameter 11 lb. packs.

TECHNICAL DATA

Typical Values

Tensile Strength:	65,000 psi, average
Elongation, in ² in.:	25%
Brinell Hardness:	92
Solidus:	1665°F (907°C)
Liquidus:	1680°F (916°C)
Brazing Range:	1720 - 1800°F (938 - 982°C)
Specific Gravity:	8.19
Density:	.295 lb/in ³
Color, as Brazed:	Yellow

Specification

2. ASME SFA5.8 Class RBCuZn-B
3. QQ-R-571C
4. MIL-R-19631B

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.

AVAILABILITY: Available in 20" length and 1/16" (2.4mm) diameter.

TYPICAL APPLICATIONS

For brazing steel, cast iron, galvanized sheet, and cast bronze and brass. Building up wear surfaces and bearings.



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