



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

# **Xuper®** **185 XFC**

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

# Xuper® 185 XFC

Xuper 185 XFC is a premium flux-coated brazing rod for applications involving wear due to frictional compressive forces. The controlled nickel addition improves application toughness and depresses fuming tendencies for welder-friendly use.

Xuper 185 was engineered for selective bearing surfaces on cast iron, steel, and some nickel alloys. Xuper 185 exhibits good deepdrawing properties.

## TECHNICAL DATA

### Typical Values

Tensile Shear Strength:	85,000 psi (586 N/mm <sup>2</sup> )
As-Deposited Hardness:	130 BHN
Work Hardened Hardness:	200 BHN
Brazing Temp. Range:	1680 - 1720°F (915 - 940°C)
Heating Methods:	Oxy-fuel, induction, air furnace
Supplemental Flux:	EutecTor® 16 or 16B* (when brazing bronzes the preferred flux is EutecTor 16B)

## PROCEDURE FOR USE

**PREPARATION:** Lightly roughen highly polished base metals to facilitate quicker bonding. Clean joint area with RotoClean® OS or use a proprietary VOC-free solvent. Align parts and preheat locally to facilitate quicker joint area heat-up. When brazing on cast iron prepare the surface by searing using an oxidizing flame. This will help to remove free graphite from the surface and help with bonding.

**TECHNIQUE:** Use a neutral to 1x carburizing flame to prevent oxidation. After preheating deposit the filler metal using a continuous “drop-and-melt” technique. Continue until the joint is slightly overfilled.

*Note: When additional fluxing is called for use EutecTor 16, and for bronzes and chromium-bearing tool steels used EutecTor 16B.*

**POST-BRAZING:** If necessary, parts can be cooled in water to “shock off” the flux residue.

## TYPICAL APPLICATIONS

- Stamping dies
- Drawing dies
- Bearing surfaces
- Guide arms
- Hydraulic seal areas



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