EutecRod 1601

Cadium-Free Silver Brazing Rod

DESCRIPTION

A bare brazing rod requiring preparatory fluxing with XuperBraze 100 or Xuper Braze 100H. Available in 18" lengths in 16/1" diameter. Packaged in 0.5 lb. and 1 lb. packs.

- Cadmium - free bare rod general purpose brazing alloy
- Widely used on joints where greater corrosion resistance is needed
- It exhibits good wetting action and flow
- Useful in bridging gaps where poor joint fitups cannot be avoided
- Excellent corrosion resistance
- Joint clearances of .008. - 003 inches recommended for proper capillary action
- Perfect for high strength joining of aluminum tee and lap 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 meta

APPLICATIONS:

Suitable for basic tungsten carbide inserts, general tool tipping and stainless food containers and food handling equipment. Used where greater corrosion resistance is required.

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 still warm, or rinse with hot water

Specification: Generally, the joint strength using 1601 will exceed the strengths of the base metals being joined. Type of joint, design of joint, joint clearances, and brazing procedures will effect the finished joint strength.

Technical Data

Solidus: 1220°F (660°C)

Liquidus: 1435°F (779°C)

Brazing Range: 1435 - 1585°F (779 - 863°C)

Electrical Conductivity: 16.8% IACS

Electrical Resistivity: 10.27 Microhm-cm

The recommended maximum operating temperature of 1601 is up to 400°F in continued service and up to 600°F in intermittent

Color, as Brazed: Light Yellow

For Joint Clear: .003 to .008 inches

DIAMETER
1.6mm
2.4mm
3.2mm
4.0mm
4.8mm