

Eutecrod 1805

Tube To Tube Sheet Joining Torch Brazing Rod For Self-Fluxing Copper-To-Copper Joints

Description

Copper-phosphorus-silver alloy, developed for the capillary joining of copper metal parts

Outstanding Features:

- Low melting brazing alloy.
- Silver-bearing; thin flowing.
- Self fluxing for copper to copper brazing.
- Strong, ductile, leak-proof joints.
- Good corrosion resistance.

Product Details

Name: Castolin 1805

Description: Flux-free capillary joining of copper

Type: Self-Fluxing Brazing Alloys for Copper

Category: Low Temperature Brazing and Soldering Alloys

Applications

Heat exchangers

Air conditioners

Refrigerating systems

Sanitary facilities

Electrotechnical equipment

PROCEDURE FOR USE

Preparation

Clean the joint surfaces and round off any sharp edges.

Degrease the parts if necessary with an appropriate solvent.

Although flux is not necessary for copper parts, it is recommended to improve the quality of the assemblies and act as an indicator for the bonding temperature.

Recommended fluxes: CASTOLIN 800 (powder form), CASTOLIN 808 PF (paste form).

Place the parts in their definitive position. Adjust the torch to obtain a neutral flame, either oxy-acetylene or oxy-propane.

Heat a broad area of the parts to be joined up to the bonding temperature.

Melt a drop and spread it with a continuous movement of the flame.

The alloy filler metal spreads to the hottest areas of the surfaces to be joined.

Melt the filler metal until the joint has been completely filled

Cleaning

Once the flux has been used, washing with hot water or soaking in cold water will remove the flux residue

Technical Data

Bonding Temperature: 1200°F (650°C)

Solidus Temperature: 1190°F (645°C)

Liquidus Temperature: 1517°F (825°C)

Tensile Strength: 250° N/mm² (36,000 psi)

DIAMETER
1.6mm
3.15mm