Xuper 145 XFC

Flux Coated Brazing Rod For Joining All Type Of Steel, Stainless Steel, Cu Alloy, Cast Iron & Galvanized Steel

Description :

Braze welding alloy with a controlled composition,made from high purity elements, designed to performexcellent quality joints. CASTOLIN 146 XFC is an «ELASTEC» flux-coated rod with a remarkable flexibility, allowing excellent visibility of the molten pool during the joining operation.

Outstanding Features:

- Durable and flexible flux coating.
- Retains corrosion resistance properties after brazing on galvanized surfaces.
- No smoke, fumes; clear visibility of molten pool.
- Superior wettability.
- Can be brazed directly on contaminated surface

Applications:

Exhaust manifold, metal frames, car bodies, piping, flanges, cast iron housing, copper base plumbing and galvanised sheets & tubes

PROCEDURE FOR USE

- Clean the joint surfaces and round off any sharp edges.
- If necessary, degrease with an appropriate solvent.
- If necessary, coat the surfaces to be joined with Castolin 146 or Castolin 18 flux.
- Place the parts in their definitive position.
- Adjust the welding torch to obtain a neutral flame.Heat locally up to the flux melting point.Melt the end of the rod on the joint.
- Bond the drop to the base metal, melt a new drop
- by moving forward and so on.
- Do not overheat, leave to air cool.

Cleaning :

The flux residues can be removed by a mechanical

process: emery grinding, sanding, scraping, etc.

Technical Data

Size: 3.15mm, 5.00 mm

Bonding Temperature: 1560F (850 C)

Solidus Temperature: 1190F (645°C)

Liquidus Temperature: 1517F (825°C)

Tensile Strength:448 N/ mm2 (65,000 psi).

DIAMETER
2.5mm
3.15mm