

Xuper 185 XFC

Nickel Enhanced, Copper-Base, Brazing Rod For Tough Re-Builds And Low Frictional Overlays

DESCRIPTION

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.

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

APPLICATIONS

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

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.

Technical Data

Tensile Strength: 586 N/mm² (85,000 psi)

Typical hardness:

As-Deposited : 130 HB

Work Hardened : 200 HB

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)

DIAMETER
2.5mm
3.15mm