

# EutecRod 1601



Cu to SS Tube Brazing

Low temperature silver brazing alloy for high strength joining of dissimilar metals

### Typical Applications:

Carbide tipping, joining sheet metal, joining tubular steels, alloy and mild steel to stainless steel.

### Outstanding Features:

- High strength joints.
- Little or no finishing.
- No melting of base metal.

### Recommendation:

Low temperature silver brazing alloy for high strength joining on all metals except white metals. Excellent for joining brass, mild steel and alloy steel to stainless steel. For thin flowing applications on lap, T, square, butt and flange joints. Ideal for thin and dissimilar metals. Excellent for tool room applications.

### Procedure:

Clean joint area. Highest strength joints obtained with clearance of 0.075 mm. Paint Eutector Flux 1601 on the rod and on joint area. Clamp parts where necessary. Heat broadly, using slightly excess acetylene. Keep distance 25 to 75 mm between the flame cone and base metal. Heat until flux liquefies. Keeping torch in constant motion, apply alloy till it flows completely through the joint. Remove flux residues.

Rod: 1.6, 2.0, 3.15mm

Shim: 25mm x 0.075 mm

Bonding Temperature: 660°C

Tensile Strength: 42 kg/mm<sup>2</sup>  
(60,000 psi).