



Eutecrod 190

High strength thin flowing alloy
For low temperature brazing of aluminium.

Description :

190 is an aluminium alloy with a very low bonding temperature and close colour match to all aluminium alloys. It is tripple de-oxidised and copper free for superior strengty and ductility. The bonding temperature of 190 is 85°C below the melting point of pure aluminium. Its corrosion resistance and electrical conductivity is comperable to the base metal specification of most popular aluminium alloys. It is ideal for use on thin aluminium sheets, shapes and sand or permanent mould castings

Principal Applications:

Because of its ability to produce strong, ductile, colour matching joints, on aluminium and aluminium alloys plates, sheets, bars and pipes, 190 is especially suited for repairing furniture, window frames and appliances.

Air conditioning piping and automotive applications.

Recomendations:

190 is used for oxy-acetylene applications. On sheet, wrought and cast forms of aluminium. Its characterized by exceptional thin flowing properties and high strength. This high quality rod also features smooth, thin fillets, excellent electrical conductivity and joins aluminium without fusion of the base metal.

Deposits on close fit joints are smooth and thin. Works best on low alloyed aluminium and those types that are not heat treated or cold worked. Apply at low base metal heat as possible.

Typical Analysis:

Tensile Strength:	235MPa
Melting Temperature:	560°C
Corrosion Resistance:	Good
Aluminium:	Good

Procedure :

Clean joint area, the oxide layer must be removed, for best results, clearance should be 0.1-0.2mm

Preheat using excess acetylene flame. Keep torch 25-75mm from base metal surface. Apply a small amount of 190 Flux to the joint area, when the flux turns to a clear fluid apply the 190 filler rod to the joint area. Keep the flame moving 25-50mm over the filler material. The filler should flow out along the joint. Care should be taken not to over heat the base material.

Allow to cool slowly. Remove the flux residue by quenching while part is at 100°C

Rod Identification & Pack Size:

Rod Identification:	Yellow Tip
Diameters Available:	1.6mm & 3.2mm
25 Rod pack,	0.5kg, 1.0kg, 2.5kg

Recomended Flux

Use with Eutectic Flux 190.

DIGITALWELD

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