



EAGLE 1850 FC

Flexible Flux Coated High Strength Nickel Silver

APPLICATIONS

Low temperature alloy used for build-up and to join carbon steels, alloy steels and cast Iron. Build-up on gear teeth, bearings, shafts, pistons and valve seats.

PROCEDURE

Clean rust, dirt and grease from the parent metal. Use a neutral flame, pre-heat the general area to 700° F and then heat the joint area to 1200° F. Melt a small amount of flux off the end of the rod and allow it to flow throughout the weld area. Then add the **EAGLE 1850 FC** alloy. Allow work piece to cool before removing the flux residue.

GENERAL CHARACTERISTICS

The **EAGLE 1850 FC** is a flux coated nickel silver alloy that produces a deposit with excellent corrosion resistance, high ductility and good resistance to friction. It is fully machinable and has good work hardening capabilities.

TECHNICAL DATA

Tensile Strength: Approx. 70,000 psi
Yield Strength: Approx. 60,000 psi
Elongation: Approx. 25% - 28%
Work Hardens (BN) Approx. 260
Working Temperature: 1595 °F / 878 °C
Melting Point: 1583 °F / 870 °C

WELDING PARAMETERS

Use Neutral Flame
Sizes: Inches 1/8 5/32 3/16
mm 3.25 4.00 5.00



≡ HIGH QUALITY WELDING PRODUCTS ≡

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REVISED 01 2024