



EAGLE 400 FC

Flexible Flux Coated Cadmium Free Silver Solder

APPLICATIONS

Low temperature flux coated alloy for joining brass, copper, stainless steel and alloy steel.

PROCEDURE

Clean the oxides off the parent metal. Use a slightly carburizing flame and pre-heat to 350° F (200° C) and then heat the joint area to 800° F (420° C). 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 400 FC** alloy. Allow work piece to cool before removing the flux residue.

GENERAL CHARACTERISTICS

The **EAGLE 400 FC** has a fast flow flux that provides excellent base metal cleaning.

TECHNICAL DATA

Tensile Strength: Approx. 68,000 psi
Yield Strength: Approx. 54,000 psi
Elongation: Approx. 25%
Working Temp: 1245° F / 674° C
Melting Range: 1175° F / 639° C

WELDING PARAMETERS

Slightly Carburizing Flame
Sizes: Inches 1/16 3/32
mm 1.60 2.50



≡ HIGH QUALITY WELDING PRODUCTS ≡

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FOR TECHNICAL ASSISTANCE CALL US TOLL FREE 1-800-447-1415

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