

### Key Facts

- 5% Silver content
- Brazing temperature approx 860 C
- High strength, self-fluxing torch alloy for copper to copper; and copper to brass with flux.
- Designed to produce smooth thin fillets in clean copper-to-copper joints without flux.
- Provides excellent corrosion resistance and will withstand severe vibrations.
- Use with flux for joining copper to brass or bronze.
- Not recommended for steel or nickel alloys

### Description

This alloy is used for the brazing of non-ferrous metals giving a strong joint on copper, brass and bronze. Excellent capillary action.

### Classification, Approvals & Conformances

AWS/ASME A5.8 BCuP3

### Applications

Used to braze copper and its alloys. Can be used to bridge gaps where close fit-up can't be maintained. Also suitable in the joining of copper and tubing on electrical work.

- Brazing copper and copper alloys
- Good for bridging gaps on poor fitting components
- Fabricate and repair copper air conditioning components, refrigeration components, radiators, heat exchangers, and other devices made from copper sheet and fittings.
- Join copper bus bards, electrical conduit, cable, and fabricated copper vessels.
- Join copper without flux in applications where flux is detrimental.

### Typical Analysis/Composition

| Ag - Silver | P – Phosphorus | Cu - Copper | Other |
|-------------|----------------|-------------|-------|
| 4.5 – 5.5   | 5.0 – 7.0      | Balance     |       |

### Typical Weld Mechanical Properties

|                          |             |
|--------------------------|-------------|
| <b>Tensile Strength:</b> | 400 MPa     |
| <b>Solidus:</b>          | 643°C       |
| <b>Liquidus Temp:</b>    | 812 – 819°C |
| <b>Brazing Temp:</b>     | 716 – 816°C |

### Packaging & Ordering Information

| Size  | Weight | Part Number |
|-------|--------|-------------|
| 2.4mm | 1kg    | 300202      |
| 3.2mm | 1kg    | 300203      |

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.