

Most copper-phosphorus feed metals are fluid enough to allow brazing at a temperature well below liquidus.

It is strongly recommended not to use these alloys for ferrous metals and nickel alloys or copper alloys containing nickel.

NORMES	EN ISO 1044/1999..... B - Cu 89 P Ag – 645/815
STANDARD	Abrégé..... CP 104
	DIN 8513..... L – Ag 5 P
	ISO 17672 : 2010 CuP 281
	AFNOR A81362..... 06 B 2
	AWS A5.8/A5.8M..... BCuP-3
	ASME Sec II-C SFA-5.8 BcuP-3
	Code douane74082100
	Selon Règlement CLPNo hazard

In compliance with regulations: CLP, Reach, RoHS / CERoHS, WEEE, ErP-2009

MANUFACTURING SPECIFICATION IN RELATION TO THE STANDARD

Standard values	Composition %								STANDARDS
	Cu	Ag	P	Sn	Si	Zn	Ni	Cd	Code
ISO 17672	Bal	4,8<>5,2	5,8<>6,2		No				CuP 281

Guideline values of the manufacturing specification Alliages Industries

Values of our Specification	Composition %								Spec AI
	Cu	Ag	p	Sn	Si	Zn	Ni	Cd	Code
105	Bal	4,8<>5,2	5,8<>6,2		No				105

Note: The maximum impurity limits are (% by mass): Cd 0.010, Pb 0.025

Standard laboratory tested in accordance with ISO 17672. Certificate available on request.

Paid analysis for a specific batch.

PHYSICAL PROPERTIES OF THE ALLOY	Min soldering temperature (note 1)	710 °C
	Mpa.....	570
	A % to 20°C	8
	Electrical conductivity% IACS....	9,60
	Electrical resistivity (Microhm-cm)	18,10
	Melting range	645 - 815°C
	Density	8,1

No silicon.

Very precise brazing temperature at +/- 10°

FORMSBARS RODS**TOLERANCES**

Diameter : 16/10 - 20/10 - 25/10 - 30/10 - 40/10 - 50/10 - 60/10 - 70/10
Achievable dimensions : Length 1000 mm, 500 mm, 350 mm, 330 mm

FOILS

Thickness 0,15 < > 2,00 mm (Tolerances mm : +/- 0,005/0,035)
Width 2,00 < > 80 mm (Customer Specification)
Arrow Max 15 mm/ meter
Packaging Wood or plastic spool.

COMPATIBLE

PASTE : CarboFLUX NT (On copper) MaxiFLUX H (For copper, iron and stainless)

DEOXIDIZING

POWDER : SuperFLUX

FLUX COATING : XF

SAFETY

NUMBER-5001

DATA SHEET (SDS)

Classification system : according to EC regulation No. 1272/2008 CLP

Symbol : None

Indications of HAZARD : None

Sentences H : None

Sentences P :

P260 – Do not breathe dust / fume / gas / mist / vapors / spray.

P270 – Do not eat, drink or smoke when using this product.

P280 – Wear protective gloves / protective clothing / eye protection / face protection

P285 – When room ventilation is insufficient, wear respiratory protection equipment.
(provide fume extraction at the brazing station)