

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 80 P Ag – 645/800
STANDARD	Abstract.....	CP 102
	DIN 8513	L – Ag 15 P
	ISO 17672	CuP 284Si
	BS 1845	CP 1
	AWS A5.8/A5.8M.....	BCuP-5
	ASME Sec II-C SFA-5.8.....	BcuP-5
	Customs code	74082100
	According to CLP Regulation.....	No 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	14,5<>15,5	4,8<>5,2		0,05<>0,25				CuP 284Si

Guideline values of the manufacturing specification Alliages Industries

Values of our Specification	Composition %								Spec AI
	Cu	Ag	p	Sn	Si	Zn	Ni	Cd	Code
115X	Bal	14,5<>15,5	4,8<>5,2		0,05<>0,25				115X

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)	700 °C
	Mpa.....	530
	A % to 20°C	10
	Electrical conductivity% IACS....	9,90
	Electrical resistivity (Microhm-cm)	17,4
	Melting range	645 - 800°C
	Density	8,4

Silicon-stabilized alloy, no bubbling. Without Degassing.

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 0,10 < > 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)