

FONTARGEN AP 2005

Copper-phosphorus-tin brazing paste



ISO 17672:	CuP 386
DIN EN 1044:	CP 302
DIN 8513:	L-CuSnP7
EN ISO 3677:	B-Cu86SnP-650/700

Composition, typical analysis (% w/w):

Cu	Sn	P
86.2	7	6.8

Mechanical and physical properties:

Working temperature:	690 °C
Melting range:	650 - 700 °C
Specific gravity:	8.8 g/cm ³ (Metal content)

Characteristics / Applications:

Filler metal with good flowing properties and capillarity. Suitable for gap brazing of copper and copper alloys. High colour similarity with brass. Easy electroplating of the soldering seam. For brazing joints with working temperatures between -20 °C and +150 °C. Do not use in sulphurous environment and on Fe- and Ni-alloys.

Heat sources:

Acetylene torch, air-gas torch, furnace, induction and resistance heating.

Flux:

None - For copper applications there is no need of flux

Storage:

Keep sealed, under stable temperatures in dry rooms. Optimum temperature range is between 5 and 20 °C. Stir well before use.

Shelf life:

6 months in pots; 3 months in cartridges

Availability:

On request

Pots	Cartridges
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

13/10/JL/1