

TECHNICAL SHEET

Ag0,4CuP

SPRING
WELDING ALLOYS

Product name

Ag0,4CuP

Class of product

Silver-Copper-Phosphorous brazing alloy

Corresponding standards

DIN8513 ---

EN1044 ---

AWS A5.8-04 ---

Nominal composition (weight %)

Ag: 0,4

Cu: 93

P: 6,6

Physical characteristics

Melting range (Solids – Liquids): 650 - 810 °C

Brazing temperature: 740 °C

Density: 8,2 g/cm³

Tensile Strength: 58 kg / mm²

Range of application:

Ag0,4CuP is a silver-copper-phosphorous brazing alloy, with very good flow characteristics.

Ag0,4CuP can be used to join copper to copper or copper based base materials (e.g. bronzes / brasses).

It is primarily used to join copper to copper in vibration-free joints.

The phosphorus contained in the alloy acts as a fluxing agent, so that it is not necessary to use an additional flux when brazing copper to copper; however when joining copper based materials (e.g. bronzes / brasses) a proper flux should be used.

Ag0,4CuP should not be used when joining parts that could come into contact in operation with sulphur containing medias, and should not be used on ferrous or nickel alloys, due to the formation of brittle intermetallic compounds which will cause failure of the joint.

Typical brazing processes include flame and induction brazing.

Typical applications are in plumbing, in the electric industry and in the refrigeration and air conditioning industry.

Characteristics Make-up:

Rods: Ø 1,5 4,0 mm; ■ 1,5 4,0 mm Length: 500 / 1.000 mm

Wires: Ø 0,5 3,0 mm (spooled and coiled)

Other dimensions are available upon request

The above data are subject to change without notice by Spring.

SPRING WELDING ALLOYS

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