

# TECHNICAL SHEET



## Ag15CuP

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### Product name

Ag15CuP

### Class of product

Silver-Copper-Phosphorous brazing alloy

### Corresponding standards

DIN8513 L-Ag15P

EN1044 CP 102

AWS A5.8-04 BCuP-5

### Nominal composition (weight %)

Ag: 15

Cu: 80

P: 5

### Physical characteristics

Melting range (Solids – Liquids): 650 - 800 °C

Brazing temperature: 700 °C

Density: 8,4 g/cm<sup>3</sup>

Tensile Strength: 54 kg / mm<sup>2</sup>

### Range of application:

Ag15CuP is a silver-copper-phosphorous brazing alloy, with excellent flow characteristics.

Ag15CuP can be used to join copper to copper or copper based base materials (e.g. bronzes / brasses).

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.

Ag15CuP 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, induction and furnace brazing.

Among the copper-phosphorous class of brazing alloys, Ag15CuP exhibits the most sluggish flow characteristics, which enables it to fill gaps better.

Typical applications are in the refrigeration, air conditioning and electromechanic industries.

### Characteristics Make-up:

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

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

Strips: Thickness: 0,1 \_ 1 mm Width: 1,5 \_ 120 mm

Rings

Preforms from Wire and from Strip

Pastes & Powders

Other dimensions are available upon request

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

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## **SPRING WELDING ALLOYS**

Hangzhou City, Zhejiang, China

Phone – 0086-13588821060

[info@springwelding.com](mailto:info@springwelding.com) - [www.springwelding.com](http://www.springwelding.com)