TECHNICAL SHEET

CuP7Sn

SPRING WELDING ALLOYS

Product name

CuP7Sn

Class of product

Copper-Phosphorous brazing alloy

Corresponding standards

DIN8513 L-CuSnP7

EN1044 CP 302

AWS A5.8-04 BCuP-9

Nominal composition (weight %)

Cu: 86

P: 7

Sn: 7

Physical characteristics

Melting range (Solids – Liquids): 650 - 700 °C

Brazing temperature: 690 °C

Density: 8 g/cm_3

Tensile Strength: 60 kg / mm_2

Range of application:

CuP7Sn is a copper-phosphorous-tin brazing alloy, with very good flow characteristics.
CuP7Sn can be used to join copper to copper or copper based base materials (e.g. bronzes / brasses). The alloy has the ability of producing a large shoulder, or cap, around the joint.
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.
CuP7Sn 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.
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)

Rings
Pastes & Powders
Other dimensions are available upon request

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

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