

# Technical Data Sheet

F-Labo-044 V11

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Version: 5

Cancels and replaces previous versions

# **BRASURE CUIVRE PHOSPHORE ARGENT**

## **Functionality**

Copper/phosphorous/silver based alloy presented in the form of rods and intended for hard soldering.

- Main application: sanitary and central heating pipes.
- Hard soldering of yellow metal parts: copper, brass, bronze.
- Not suitable for use on ferrous metals, nickel alloys or copper alloys containing nickel, in this case use All metals solder (BRASURE TOUS METAUX).
- For tin and lead alloys use soft soldering.

#### **Labels and Accreditation**

NF EN ISO 17672 : CuP 281

NF EN ISO 3677: B-Cu 89Ag-645/815

#### **Technical characteristics**

| Characteristics                 | Specifications          |
|---------------------------------|-------------------------|
| Indicative composition          | Copper: 88.2 - 89.8%    |
|                                 | Phosphorous: 5.7 - 6.3% |
|                                 | Silver: 4.5 - 5.5%      |
| Wire diameter                   | 20/10 <sup>ths</sup>    |
| Fusion interval                 | +645°C to +815 °C       |
| Minimum brazing temperature     | +710°C                  |
| Length                          | 350 mm                  |
| Ultimate tensile strength       | 65 MPa                  |
| Elongation at break coefficient | 8%                      |

#### Use

## **Preparation**

- Abrade the parts to be joined with steel wool or workshop roller.
- Brazing copper: it is not necessary to use soldering flux.
- Brazing copper alloys (brass, bronze, etc.): use soldering flux AG-FLUX.

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#### Instructions for use

- Coat the parts to be assembled with DECAPANT POUR BRASURE using the PINCEAU POUR DECAPANT when brazing copper alloys and also coat the tip of the rod.
- Fit the parts together and heat up by sweeping the flame.
- Apply the rod immediately and allow it to melt.
- Stop deposing the filler metal as soon as a ring forms at the base of the joint.
- Allow to cool and remove any excess with a damp cloth.

#### Material cleaning

With a damp cloth

## Safety precautions

The Material Safety Data Sheet is available on the Internet on www.guickfds.com or on www.geb.fr.

If the product is subject to detergent regulation: Component list available on request at reach@geb.fr

If the product is subject to biocide regulation or if it contains a biocide to protect it: Consult the Material Safety Data Sheet - Please use the products responsiblly.

#### **Comments**

Not suitable for use on ferrous metals, nickel alloys or copper alloys containing nickel.

#### **Storage**

The expiry date on packaging is for unopened product stored at 20°C in normal hygrometry conditions.

#### Packaging and waste sorting

Refer to the information on the product and to the applicable local regulations.

The information contained on the technical datasheet is provided in all good faith and results from measurements made in our laboratory. Given the number of materials, differences in quality and diversity of working methods, we recommend that users perform tests prior to application under actual conditions of use.

This document may be amended in keeping with product development and the state of our knowledge without prior notice and therefore it is recommended to check on <a href="http://www.geb.fr">http://www.geb.fr</a> that you have the latest version before use.

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