

## L-CuPSn7

**CATEGORY** Brazing

**APPLICATIONS** Suitable for gap brazing of copper and copper alloys. Joint-brazing at working temperatures between -20°C and +150°C. Do not use in sulphurous environment and on Fe- and Ni-alloys.

**PROPERTIES** Filler metal with good flowing properties and capillarity. Colour very similar to brass. Soldering seam can be easily electroplated. Self pickling on copper to copper joints.

**CLASSIFICATION**

AWS	A 5.8: no standard
EN ISO	17672: CuP 386
DIN	8513: L-Cu Sn P 7

**SUITABLE FOR** Brazing of copper, copper alloys, brass,

**APPROVALS** CE approved

**WELDING POSITIONS:**



**FILLER METAL ANALYSIS %**

Ag	Cu	P	Sn
-	86	7	7

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	Weight (g/cm <sup>3</sup> )	operating temperature (°C)	Impact Energy (J) ISO-V -40°C      -60°C	Melting range (°C)
as brazed		250	8	690		645-695

**BRAZING PARAMETERS / PACKING**

Welding Parameters		flame type	Optimum brazing	Packing	
D (mm)	Length (mm)	adjustment	Gab (mm)	kg tubes / cartons	kg / spools
2.0	500	neutral	0.06-0.15	1 / 5 / 20	1 till 10
3.0	500	neutral	0.06-0.15	1 / 5 / 20	1 / 5 / 25

**REDRYING TEMPERATURE** not required