

L-Ag15P

CATEGORY Brazing

TYPE Copper phosphorus silver brazing alloy.

APPLICATIONS Copper to copper (without flux). Brass, copper and copper-tin alloys (with flux). Do not use in a sulphurous environment. For working temperatures up to 200°C

PROPERTIES Phosphorus silver brazing alloy. Self picking on copper. Used for strong brazing of uneven junctions. Good mechanical characteristics at low temperatures.

CLASSIFICATION

AWS	A 5.8: BCuP-5
	UNS: C55284
EN ISO	17672: CuP 284
DIN	8513: L-Ag15P

SUITABLE FOR Particularly recommended for sanitary and refrigerating installations.. Applications: Copper to copper (without flux). Brass, copper and copper-tin alloys (with flux). Do not use in a sulphurous environment.

WELDING POSITIONS:



FILLER METAL ANALYSIS %

Ag	Cu	P	others total
14,5-15,5	rem	4,8-5,2	<0,15

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	Weight (g/cm ³)	Operating temperatur (°C)	Impact Energy (J) ISO-V -40°C -60°C	Melting range (°C)
untreated		250	8.4	710		645-770

BRAZING PARAMETERS / PACKING

Brazing Parameters		Flame type	Optimum brazing	Packing	
D (mm)	Length (mm)	Adjustment	Gab	kg / tubes	kg / spools
1,5	500	neutral	0.06 - 0.13 mm	1 / 5 / 25	1 till 10
2.0	500	neutral	0.06 - 0.13 mm	1 / 5 / 25	1 till 10
3.0	500	neutral	0.06 - 0.13 mm	1 / 5 / 25	1 till 10

REDRYING TEMPERATURE not required

OTHER DELIVERY FORMS Customized rings and or strip for automatized brazing