

## 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	1044: CP 102 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.

**APPROVALS** CE approved

**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 <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 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