

## L-Ag18P

**CATEGORY** Brazing

**TYPE** Special eutectic Copper-Silver-Phosphor brazing alloy.

**APPLICATIONS** Particularly recommended for sanitary and refrigerating installations, boilers, heat exchangers, tubing etc. Do not use in a sulphurous environment. For working temperatures up to 200°C

**PROPERTIES** Eutectic alloy self pickling on copper. Exceptional fluidity. It is very well suitable for the repair of the capillary losses of brazed joints with lower silver containing Phos-copper alloys. Ideal where the heat feeding is critical because of its low operating temperature.

**CLASSIFICATION**

AWS	A 5.8: no standard
EN ISO	1044: CP 101 17672: CuP 286
DIN	8513: L-Ag18P

**SUITABLE FOR** 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	other total
18	75	7	<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 temperature °C	Impact Energy (J) ISO-V -40°C    -60°C	Melting range °C
untreated		250	8.4	650		645-645

**BRAZING PARAMETERS / PACKING**

Sizes		Flame type	Optimum brazing	Packing	
D (mm)	Length (mm)	Adjustment	Gab (mm)	kg / tube / carton	kg / spool
1,5	500	Neutral	0,01-0,16	1 / 5 / 20	1 till 10
2,0	500	Neutral	0,01-0,16	1 / 5 / 20	1 till 10
3,0	500	Neutral	0,01-0,16	1 / 5 / 20	1 till 10

**REDRYING TEMPERATURE** not required

**OTHER DELIVERY FORMS** Customized brazing rings.