

L-Ag18PL

CATEGORY Brazing

TYPE Special 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 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: BCuP-8 UNS: C55385
EN ISO	3677: B-Cu76AgP-643/666 17672: CuP 285
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	others total
17,2-18,0	rem	6,0-6,7	<0,15

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2}	R _m	Weight g/cm ³	Operating temperature °C	Impact Energy (J) ISO-V		Melting range °C
	(N/mm ²)	(N/mm ²)			-40°C	-60°C	
untreated		250	8.4	670			643-666

BRAZING PARAMETERS / PACKING

Sizes		Flame type Adjustment	Optimum brazing Gab (mm)	Packing	
D (mm)	Length (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.