


L-CuP7 Sn

CATEGORY	Brazing																																								
TYPE	Copper phosphorus brazing alloy.																																								
APPLICATIONS	Joining: Copper to copper, Copper alloys, Brass, Copper-Sn alloys with flux. Do not use this alloy above working temperatures of 200°C																																								
PROPERTIES	Universal brazing alloy containing phosphor for use without additional flux on copper to copper joints. Good flowing characteristics. Very easy to use with high mechanical properties.																																								
CLASSIFICATION	AWS	A 5.8: BCuP-2																																							
	EN ISO	17672: CP 202																																							
	DIN	8513: L-CuP7																																							
SUITABLE FOR	Copper to copper (without flux), Copper alloys, Brass, Copper-Sn alloys with flux.																																								
APPROVALS	CE approved																																								
WELDING POSITIONS:																																									
FILLER METAL ANALYSIS %	<table border="1"> <tr> <td>P</td> <td colspan="5">Cu</td> </tr> <tr> <td>7</td> <td colspan="5">Rest</td> </tr> </table>						P	Cu					7	Rest																											
P	Cu																																								
7	Rest																																								
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} (N/mm²)</th> <th>R_m (N/mm²)</th> <th>Weight g/cm³</th> <th>Operating temperature °C</th> <th>Impact Energy (J) ISO-V -40°C -60°C</th> <th>Melting range (°C)</th> </tr> </thead> <tbody> <tr> <td>As brazed</td> <td></td> <td>250</td> <td>8.1</td> <td>720</td> <td></td> <td>710-820</td> </tr> </tbody> </table>						Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	Weight g/cm ³	Operating temperature °C	Impact Energy (J) ISO-V -40°C -60°C	Melting range (°C)	As brazed		250	8.1	720		710-820																					
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	Weight g/cm ³	Operating temperature °C	Impact Energy (J) ISO-V -40°C -60°C	Melting range (°C)																																			
As brazed		250	8.1	720		710-820																																			
BRAZING PARAMETERS / PACKING	<table border="1"> <thead> <tr> <th colspan="2">Brazing Parameters</th> <th>Flame type</th> <th colspan="2">Optimum brazing</th> <th colspan="2">Packing</th> </tr> <tr> <th>D (mm)</th> <th>Length (mm)</th> <th>Adjustment</th> <th>Gab (mm)</th> <th>kg</th> <th colspan="2">kg / spools</th> </tr> </thead> <tbody> <tr> <td>1.5</td> <td>500</td> <td>Neutral</td> <td>0.03-0.08</td> <td>1</td> <td colspan="2">1 till 10</td> </tr> <tr> <td>2.0</td> <td>500</td> <td>Neutral</td> <td>0.03-0.08</td> <td>1</td> <td colspan="2">1 till 10</td> </tr> <tr> <td>3.0</td> <td>500</td> <td>Neutral</td> <td>0.03-0.08</td> <td>1</td> <td colspan="2">1 till 10</td> </tr> </tbody> </table>						Brazing Parameters		Flame type	Optimum brazing		Packing		D (mm)	Length (mm)	Adjustment	Gab (mm)	kg	kg / spools		1.5	500	Neutral	0.03-0.08	1	1 till 10		2.0	500	Neutral	0.03-0.08	1	1 till 10		3.0	500	Neutral	0.03-0.08	1	1 till 10	
Brazing Parameters		Flame type	Optimum brazing		Packing																																				
D (mm)	Length (mm)	Adjustment	Gab (mm)	kg	kg / spools																																				
1.5	500	Neutral	0.03-0.08	1	1 till 10																																				
2.0	500	Neutral	0.03-0.08	1	1 till 10																																				
3.0	500	Neutral	0.03-0.08	1	1 till 10																																				
REDRYING TEMPERATURE	Not required																																								
OTHER DELIVERY FORMS	Endless wire on spools (D-300) and customized rings.																																								