

L-CuPSn7

CATEGORY Brazing

APPLICATIONS Suitable for gap brazing of copper and copper alloys. Joint-brazing at working temperatures between -20°C and +150°C. Do not use in sulphurous environment and on Fe- and Ni-alloys.

PROPERTIES Filler metal with good flowing properties and capillarity. Colour very similar to brass. Soldering seam can be easily electroplated. Self pickling on copper to copper joints.

CLASSIFICATION

AWS	A 5.8: no standard
EN ISO	17672: CuP 386
DIN	8513: L-Cu Sn P 7

SUITABLE FOR Brazing of copper, copper alloys, brass,

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS %

Ag	Cu	P	Sn
-	86	7	7

MECHANICAL PROPERTIES

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	Impact Energy (J) ISO-V -60°C	Melting range (°C)
as brazed		250	8	690			645-695

BRAZING PARAMETERS / PACKING

Welding Parameters		flame type adjustment	Optimum brazing Gab (mm)	Packing	
D (mm)	Length (mm)			kg tubes / cartons	kg / spools
2.0	500	neutral	0.06-0.15	1 / 5 / 20	1 till 10
3.0	500	neutral	0.06-0.15	1 / 5 / 20	1 / 5 / 25

REDRYING TEMPERATURE not required