

Brazing Rods Data Sheet



Type of Product
5% Silver Brazing Alloy

Composition
5% Silver
89% Copper
6% Phosphorous

Impurities to BSEN 17672 Group CP
Alloy conforms to
BSEN 17672 CuP104

Melting Range

645 - 815°C

Appearance
Copper coloured metal

Occupational Health Data

TLV
Odour threshold

Silver 0.1mg/m3 as fume

Phosphorous 1mg/m3 as
phosphoric acid

Copper 0.2mg/m3 as fume

Working Temp

710°C

Tensile Strength 600N/mm²
Hardness 190

Elongation 7%

Electrical Conductivity 10%
I.A.C.S. at 20°C

Type of Product
2% Silver Brazing Alloy

Composition
2% Silver
91.7% Copper
6.3% Phosphorous

Impurities to BSEN 17672 Group CP
Alloy conforms to
BSEN 17672 CuP104

Melting Range

645 - 825°C

Appearance
Copper coloured metal

Occupational Health Data

TLV
Odour threshold

Silver 0.1mg/m3 as fume

Phosphorous 1mg/m3 as
phosphoric acid

Copper 0.2mg/m3 as fume

Working Temp

740°C

Tensile Strength 490N/mm²
Hardness 195

Elongation 5%

Electrical Conductivity
9% I.A.C.S. at 20°C

Type of Product
Square 0.2% Silver Brazing Alloy

Composition
0.2% Silver
93.5% Copper
6.3% Phosphorous

Impurities to BSEN 17672 Group CP
Alloy conforms to
BSEN 17672 CuP104

Melting Range

645 - 815°C

Appearance
Copper coloured metal

Occupational Health Data

TLV
Odour threshold

Silver 0.1mg/m3 as fume

Phosphorous 1mg/m3 as
phosphoric acid

Copper 0.2mg/m3 as fume

Working Temp

760°C

Tensile Strength 490N/mm²
Hardness 195

Elongation 5%

Electrical Conductivity 8.5%
I.A.C.S. at 20°C