

# TECHNICAL SHEET

## Ag15CuP

### Product name

Ag15CuP

### Class of product

Silver-Copper-Phosphorous brazing alloy

### Corresponding standards

ISO 17672	CuP 284
EN1044	CP 102
AWS A5.8-04	BCuP-5
DIN 8513	L-Ag15P

### Nominal composition (weight %)

Ag: 15  
P: 4,8 – 5,0  
Cu: Bal.

### Physical and technical properties

Melting range (Solidus – Liquidus): 645 - 800 °C  
Minimum brazing temperature (flow point): 700 °C  
Density: 8,4 g/cm<sup>3</sup>  
Tensile Strength (filler metal): 54 kg/mm<sup>2</sup>  
Electrical conductivity: 9,9 % IACS  
Recommended joint gap: 0,05 – 0,2 mm  
Continuous service joint operating temp.: -55 / + 150 °C  
Max. short service joint operating temp.: 200 °C

### Range of application

Ag15CuP is a silver-copper-phosphorous brazing alloy, with very good flow characteristics.

It can be used to join copper to copper or copper based base materials (e.g. bronzes / brasses).

The phosphorus contained in the alloy acts as a fluxing agent, so that it is not necessary to use an additional flux when brazing copper to copper; however when joining copper based materials (e.g. bronzes / brasses) a proper flux should be used.

Excellent service performance are obtained on joints subject to vibrations.

Ag15CuP should not be used on ferrous or nickel alloys, or alloys containing more than 10% of nickel, due to the formation of brittle intermetallic compounds which will cause failure of the joint.

Corrosion resistance of Ag15CuP is generally satisfactory, except when the joint is contact with sulphurous atmospheres (especially at high temperatures); the alloy should therefore not be used to join parts that could come into contact with sulphur containing medias.

Typical brazing processes include flame, induction and furnace brazing.

Tensile strength of joints brazed with Ag15CuP will generally exceed base metals strength.

Joint strength is however a function of various factors, such as: type of base metals to be joined, type of joint, joint clearance, brazing procedure, etc.

Typical applications are in plumbing, in the electric and electromechanic industry, and in the refrigeration and air-conditioning industry.

### Characteristics Make-up

Rods: Ø 1,5 ⇒ 4,0 mm ; □ 1,5 ⇒ 4,0 mm	Length: 500 / 1.000 mm
Wires: Ø 0,5 ⇒ 3,0 mm	Spoiled and coiled
Strips: Thickness: 0,1 ⇒ 1 mm	Width: 1,3 ⇒ 120 mm
Rings	
Preforms from Wire and from Strip	
Pastes & Powders	

Other dimensions are available upon request.

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**STELLA**  
WELDING ALLOYS

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NOTE:

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