

FONTARGEN A 2005 Copper-phosphorus-tin alloy



ISO 17672:	CuP 386
DIN EN 1044:	CP 302
DIN 8513:	L-CuSnP7
EN ISO 3677:	B-Cu86SnP-650/700

Composition, typical analysis (% w/w):

Cu	Sn	P
86.2	7	6.8

Mechanical and physical properties:

Working temperature:	690 °C
Melting range:	650 - 700 °C
Specific gravity:	8.8 g/cm ³
Tensile strength:	250 N/mm ²

Characteristics / Applications:

Filler metal with good flowing properties and capillarity. Suitable for gap brazing of copper and copper alloys. Colour very similar to brass. Soldering seam can be easily electroplated. Joint-brazing at working temperatures between -60 °C and +150 °C. Do not use in sulphurous environment and on Fe- and Ni-alloys.

Heat sources:

Acetylene torch, air-gas torch, induction and resistance heating, TIG-torch.

Flux:

Only copper alloys require the use of flux
F 300 - Series

Availability:

Bare rods	Coated rods	Wire	Foil	Preform	Powder	Paste
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