

## L-Ag15P

**CATEGORY** Brazing

**TYPE** Copper phosphorus silver brazing alloy.

**APPLICATIONS** Copper to copper (without flux). Brass, copper and copper-tin alloys (with flux). Do not use in a sulphurous environment. For working temperatures up to 200°C

**PROPERTIES** Phosphorus silver brazing alloy. Self picking on copper. Used for strong brazing of uneven junctions. Good mechanical characteristics at low temperatures.

**CLASSIFICATION**

|        |                |
|--------|----------------|
| AWS    | A 5.8: BCuP-5  |
|        | UNS: C55284    |
| EN ISO | 1044: CP 102   |
|        | 17672: CuP 284 |
| DIN    | 8513: L-Ag15P  |

**SUITABLE FOR** Particularly recommended for sanitary and refrigerating installations.. Applications: Copper to copper (without flux). Brass, copper and copper-tin alloys (with flux). Do not use in a sulphurous environment.

**APPROVALS** CE approved



**FILLER METAL ANALYSIS %**

| Ag        | Cu  | P       | others total |
|-----------|-----|---------|--------------|
| 14,5-15,5 | rem | 4,8-5,2 | <0,15        |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>p0,2</sub> (N/mm <sup>2</sup> ) | R <sub>m</sub> (N/mm <sup>2</sup> ) | Weight (g/cm <sup>3</sup> ) | Operating temperatur (°C) | Impact Energy (J) ISO-V<br>-40°C      -60°C | Melting range (°C) |
|----------------|--|-------------------------------------|-----------------------------|---------------------------|---|--------------------|
| untreated      |  | 250                                 | 8.4                         | 710                       |   | 645-770            |

**BRAZING PARAMETERS / PACKING**

| Brazing Parameters |             | Flame type | Optimum brazing | Packing    |             |
|--------------------|-------------|------------|-----------------|------------|-------------|
| D (mm)             | Length (mm) | Adjustment | Gab             | kg / tubes | kg / spools |
| 1,5                | 500         | neutral    | 0.06 - 0.13 mm  | 1 / 5 / 25 | 1 till 10   |
| 2.0                | 500         | neutral    | 0.06 - 0.13 mm  | 1 / 5 / 25 | 1 till 10   |
| 3.0                | 500         | neutral    | 0.06 - 0.13 mm  | 1 / 5 / 25 | 1 till 10   |

**REDRYING TEMPERATURE** not required

**OTHER DELIVERY FORMS** Customized rings and or strip for automatized brazing