

Technical data sheet BrazeTec D 807.1

Standard

ISO 17672 CuP 284
 (AWS 5.8) (BCuP-5)
 (DIN EN 1044) (CP 102)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

Cu Rem.; Ag 15; P 5

Al 0.01; Bi 0.030; Cd 0.01; Pb 0.025; Zn 0.05

Zn + Cd 0.05;

0.25

Technical data

Melting range acc. ISO 17672

approx. 645 - 800°C

Melting range acc. Measurement

approx. 645 - 800°C (DSC –measurement)

Recommended brazing temperature

approx. 720 °C

Density of brazing alloy

approx. 8.3 g/cm³

Density of brazing paste

approx. 3.4 g/cm³ (20 °C)

Metal content

approx. 85 wt.-%

Grain size of brazing alloy powder

< 63 µm

Viscosity

20 - 25 Pa s (Cone-Plate; 150 µm; D= 50/s; 20 °C)

Shear strength acc. DIN EN 12797

100 MPa (with Cu)

Operating temperature of joint

max. 150 °C (without loss of strength)

Cleaning agent

BrazeTec Cleaning Agent P

Shelf life

min. 6 months, but only in the original sealed container

at storage temperatures between +5 to +30°C.

stir well before use

Packaging

Standard

1; 3; 5; 10 kg

Applications

BrazeTec D 807.1 paste contains a phosphorous-containing brazing alloy with good flow characteristics. The brazing alloy is suitable for joining copper to copper or copper-based materials. Due to its phosphorous content, you do not have to use an additional flux for brazing only copper to copper.

This brazing alloy is not allowed to be used if sulfur containing Medias may have contact with the joint during operating. Further it is not allowed to use this alloy for joining steels (Fe) or materials containing iron, nickel and cobalt as brittle phases will be formed in the joint. In refrigeration and air conditioning industries BrazeTec D 807.1 can be used for service temperatures down to -50°C. It can be used for brazing with flame, with induction heating and in a furnace under protective atmospheres. Typical applications are found e.g. in the electric industry and for the refrigeration and air conditioning industry.

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