Technical data sheet Braze Tec D 807.1

**Standard**

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

**Nominal composition [wt.-%]**  
Cu Rem.; Ag 15; P 5

**Permitted impurities max. [wt.-%]**  
Al 0.01; Bi 0.030; Cd 0.01; Pb 0.025; Zn 0.05

**Max. impurities [wt.-%]**  
Zn + Cd 0.05;

**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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