PAG 60

CuP-Ag 6% brazing Alloy

Certified A.T.G. by Certigaz

TECHNICAL DATA SHEET 145

Specifications:

Alloy	Working Temperature (˚C)	ATG	NF A 81-362 (2013)	NF EN ISO 3677 (2016)
Cu-P-Ag-Ni	690	N°1530	CuP291	B-Cu87PAg(Ni) -645/725

Characteristics:

PAG 60 is a brazing alloy with 6 % Silver. An addition of 0.1 % Nickel is done to improve the ductility and mechanical characteristics of the brazed joint. **This alloy, in association with the flux AGFLUX is certified on checking number ATG N° 1530 with specification ATG B.524-3 (2020).** Alloy benefiting from a good capillarity, can be used particularly for bridges building or joining gap presenting medium to low clearances. The corrosion resistance is similar to copper, except when the brazed joint is subjected to sulfuric gases or high temperatures.

Applications:

PAG 60 It is recommended for hard brazing of copper/copper and particularly copper brass pipes of gas and combustible installations. This alloy is not recommended for brazing of alloy containing (Fe), Nickel (Ni), or Cobalt (Co) => embrittlement of joining. this alloy can be used with flame.

Application: Industrial cooling/Gaz, fluid transport, plumbing

Typical Chemical Compositions (%):

Cu	P	Ag	Ni	Si	Bi	Cd	Pb	Zn	Al	Zn + Cd	Max. impurities
Reminder	7.30	6.0	0.10	0.01	<0.03	<0.01	<0.020	<0.050	<0.01	<0.05	<0.10
Si (*) as per ATG B.524-3 (2020) Si<0.1%											

Typical Physical Properties

Colour	Solidus (˚C)	Liquidus (˚C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Copper	645	725	8.2	4%	450	-	-

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size (mm)	Type				OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
	Bare	Coated	wire	Preforms				
1.50, 1.6 and 2.00 (**)	√	-	√	√	√	√	√	√

(**) wire of 1.5 ,1.6 or 2.0 mm in spool or coil form. Bare Rods in 2.0 mm

Preform sizes and other type are solicited case to case basis

Conformity:

Conformity of the Couple: **PAG60-AGFLUX** following specification ATG B.524-3 (2020)