

TECHNICAL DATA SHEET 139

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672	AWS A-5.8	EN ISO 3677	AMS
Cu-P-Ag	710	CuP 283	BCuP-4	BCu87PAg 643/813	-

Characteristics:

PHOSBRAZ AG61 The higher the silver content, the greater the ductility of the brazed joint. This addition also refines the alloy, increasing the brazed joints mechanical characteristics and improving electrical conductivity. This is special alloy for high strength capillary brazing.

PHOSBRAZ AG61 This brazing alloy is not recommended to be used for the media having sulphur. Also it is not allowed to use for joining steels (Fe) or materials containing Iron (Fe), Nickel (Ni), Cobalt (Co) as it will form brittle phase in the joint. The corrosion resistance of this alloy is comparable to that of copper excepts, when the joint is exposed to sulphur containing gas or at elevated temperatures. Under these conditions, it is expected that, this alloy will undergo progressive deterioration as other copper phosphorus alloy with Silver or without Silver.

Applications:

PHOSBRAZ AG61 is recommended for hard brazing of copper and optionally copper brass pipes of combustible installations. As well as all low temperature applications. In Air conditioning and refrigeration application, **PHOSBRAZ AG61** can be used for the service temperature between +150°C (without loss in strength) to -50°C.

Typical Chemical Compositions (%):

Cu	P	Ag	Bi	Cd	Pb	Zn	Al	Zn + Cd	Max. impurities
Reminder	7.30	6.00	<0.03	<0.01	<0.025	<0.05	<0.01	<0.05	<0.25





Typical Physical Properties:

Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Copper	643	813	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				 OXYACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	Coil	Preforms				
1.50 ,2.00,2.50,3.00	✓	✓	-	✓	✓	✓	✓	X

Preform sizes and other type other than above standard dimensions are solicited case to case basis

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.