Selectarc BRAZING

PHOSBRAZ M60

Copper Phosphorous Brazing Alloy

TECHNICAL DATA SHEET 55

Specifications:

Alloy	Working Temperature (˚C)	NF EN ISO 17672	AWS A-5.8	DIN 8513
Cu-P	760	CuP 179	-	L-Cu P6

Characteristics:

PHOSBRAZ M60 is an Alloy with a controlled fluidity, specially made for strong brazing of fitting, pipes and Fit up, with large joint gaps. Its low phosphorus content makes it relatively sluggish. Alloy with self-fluxing properties. The corrosion resistance this alloy is comparable to that of copper excepts when the joint is exposed to sulphur containing gas or at elevated temperatures as in a cooking range. 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 M60 joining copper to copper it is act as self-fluxing alloy and does not required additional flux. It can be used on cuprous alloys (bronze, brass) with PHOSBRAZ flux. Electrical industry, Plumbing trade. 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. In Air conditioning and refrigeration application, **PHOSBRAZ M60** can be used for the service temperature between +150˚C (without loss in strength) upto -20˚C. This alloy can be used for flame…Maximum short service joint operating temperature 200˚C.

Typical Chemical Compositions (%):

Cu	P	Al	Bi	Cd	Pb	Zn	Zn + Cd	Max. impurities
Reminder	6.00	<0.01	<0.030	<0.01	<0.025	<0.050	<0.050	<0.25

Typical Physical Properties:

Colour	Solidus (˚C)	Liquidus (˚C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Copper	710	860	8.10	6%	500	7.20	24.1

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 and Types & Heating Source Recommendation:

Size (mm)	Type				OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
	Bare	Coated	Coil	Preforms				
1.50,2.00,2.50,3.00	√	–	–	–	√	√	X	X

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

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