	TECHNICAL DATA SHEET	Realease	0 17.6.2019
		Nature of mod.	First issue
		Author	RQ
		Mod	CPO/ST Rev.2 del 17/06/2019

A.V.Saldature code FH35
ISO 17672:2016 Filler metal ISO 17672-Cup 284
EN 1044: CP 102
EN ISO 3677: B Cu 80 Ag P 645/800
AWS A 5.8: BCup-9

Chemical Composition (%)

A.V.	Cu Min. Max.	P Min. Max.	Ag Min. Max.	Sn Min. Max.	Other elements Min. Max.
FH35	Rest	4,7 5,3	14,5 15,5		

NOTE Maximum impurity limits applicable to all types are (% by mass) Al 0,001, Bi 0,030, P 0,008, Pb 0,025; total of all impurities = 0,15; total of all impurities for Ag 427, Ag 449 and Ag 485 = 0,30.

Working temperature[i]: 700°C
Melting range: 6457800°C
Specific gravity: 8,7 g/cm^3
Tensile strength: 250 N/mm^2
Elongation: 10%

Characteristics / Applications:
High silver Copper phosphorus brazing alloy with excellent fluid proprieties and capillarity. Ideal for copper to copper joint and copper alloys. Recommended for joints with strong thermal load and vibrations Joint brazing at working temperature between -70°C and + 150°C. Do not use in sulphurous environment and on Fe or Ni alloys

Heat sources:
Acetylene torch, air-gas torch, induction and resistance heating

Flux: Cu P alloy does not need flux on Cu to Cu, liquid flux into vaporizer can remove the oxide and leave a better aspect of the joint.
On brass alloy D4 D26 D60 DK

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coated Rods	Wire	Foil	Perform	Powder	Paste
x		x	x	x		

[i] Unlike the majority of filler metals in this International Standard, which only flow satisfactorily at, around or above the liquidus, most copper phosphorus filler metals are sufficiently fluid for brazing at a temperature significantly below the liquidus.