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|---|-------------------------------|----------------|--------------------------------|
|  | <h1>TECHNICAL DATA SHEET</h1> | 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 FH45
 ISO 17672:2016 Filler metal ISO 17672-Cup 281
 EN 1044: CP 104
 EN ISO 3677: B Cu 89 Ag P 645/815
 AWS A 5.8: B Cup-3

| Chemical Composition (%) | | | | | |
|----------------------------|--------------|--------------|--------------|--------------|----------------|
| A.V. | Cu | P | Ag | Sn | Other elements |
| | Min. Max. | Min. Max. | Min. Max. | Min. Max. | Min. Max. |
| FH45 | Rest | 5,8 6,2 | 4,8 5,2 | | |

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 temperatureⁱ: 710 °C
 Melting range: 645/815 °C
 Specific gravity: 8,2 g/cm³
 Tensile strength: 250 N/mm²
 Elongation: 8%

Characteristics / Applications:

medium 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.