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|---|-------------------------------|----------------|--------------------------------|
|  | <h1>TECHNICAL DATA SHEET</h1> | Release        | 0 17.6.2019                    |
|   |                               | Nature of mod. | First issue                    |
|   |                               | Author         | RQ                             |
|   |                               | Mod            | CPO/ST Rev.2 del<br>17/06/2019 |

A.V.Saldature code FH55  
 ISO 17672:2016 Filler metal ISO 17672-Cup 386  
 EN 1044: CP 302  
 EN ISO 3677: B Cu 86 P Sn 650/700  
 AWS A 5.8: -

| Chemical Composition ( % ) |              |              |              |              |                |
|----------------------------|--------------|--------------|--------------|--------------|----------------|
| A.V.                       | Cu           | P            | Ag           | Sn           | Other elements |
|                            | Min.<br>Max. | Min.<br>Max. | Min.<br>Max. | Min.<br>Max. | Min.<br>Max.   |
| FH55                       | Rest         | 6,4<br>7,2   |              | 6,5<br>7,5   |                |

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<sup>i</sup>: 690 °C  
 Melting range: 650/700' °C  
 Specific gravity: 8,8 g/cm<sup>3</sup>  
 Tensile strength: 250 N/mm<sup>2</sup>

#### Characteristics / Applications:

Copper phosphorus tin brazing alloy with good proprieties and capillarity. Ideal for copper to copper joint and copper alloys widely use on brass. Joint brazing at working temperature between -20°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       | x      | x     |

<sup>i</sup> 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.