



COPPER-PHOSPHORUS ALLOYS

- Excellent fluidity
- High capillarity on small gaps
- Good control for joint filling
- Guaranteed melting point $\pm 3^{\circ}\text{C}$

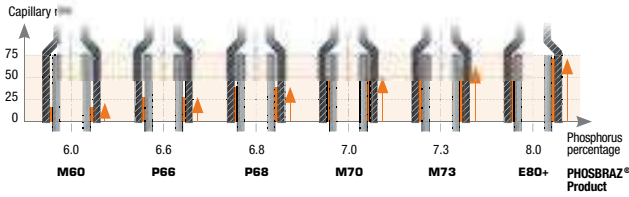
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BRAZING



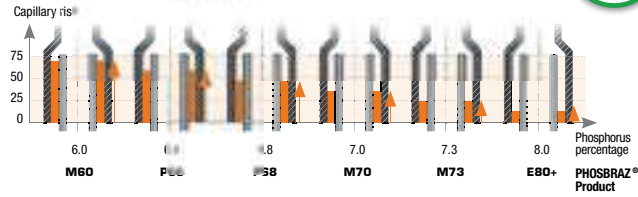
SCHEMATIC REPRESENTATION OF THE CAPILLARY - ACTION OF PHOSBRAZ® (CuP) ALLOYS



IN CASE OF SMALL CLEARANCES (such as < 0.05 mm)



IN CASE OF LARGE CLEARANCES (such as > 1 mm)

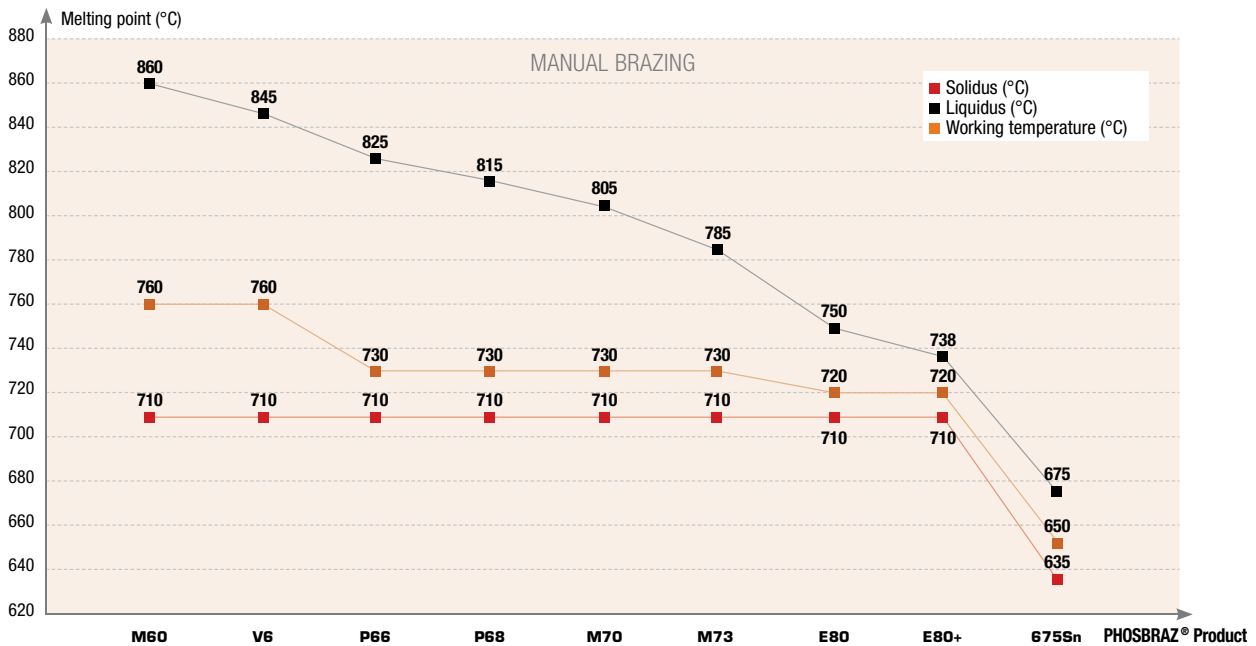


Non-contractual drawings.

SELECTION CRITERIA BASED ON FLUIDITY OF THE CuP ALLOY RANGE

Reference	Fluidity	Characteristics
PHOSBRAZ E80+ PHOSBRAZ 675Sn	VERY HIGH FLUIDITY ●●●●●	These alloys melt at low temperature. Joints with very small clearances.
PHOSBRAZ E80	HIGH FLUIDITY ●●●●	This alloy melt at low temperature. Joints with very small clearances.
PHOSBRAZ M70 PHOSBRAZ M73	GOOD FLUIDITY ●●●	These grades are used for brazing of couplings and connectors. Standard clearances.
PHOSBRAZ P66 PHOSBRAZ P68	INTERMEDIATE FLUIDITY ●●	Brazing of joints in position.
PHOSBRAZ M60 PHOSBRAZ V6	VISCOUS ●	Recommended for tube-assembly by pitting.

SELECTION CRITERIA: MELTING POINT / WORKING TEMPERATURE



Type	Technical characteristics			Chemical composition					
	■ Solidus (°C)	■ Liquidus (°C)	■ Working temperature (°C)	Rm (MPa)	A (%)	P (%)	Sn (%)	Cu (%)	
MANUAL BRAZING ■ PHOSBRAZ M60	710	860	760	550	6	6	-	Balance	
■ PHOSBRAZ V6	710	845	760	550	5	6.3	-	Balance	
■ PHOSBRAZ P66	710	825	730	500	4	6.6	-	Balance	
■ PHOSBRAZ P68	710	815	730	450	4	6.8	-	Balance	
■ PHOSBRAZ M70	710	805	730	450	4	7	-	Balance	
■ PHOSBRAZ M73	710	785	730	450	4	7.3	-	Balance	
■ PHOSBRAZ E80	710	750	720	450	3	7.8	-	Balance	
■ PHOSBRAZ E80+	710	738	720	450	2	8	-	Balance	
■ PHOSBRAZ 675Sn	635	675	650	350	2	6.75	7	Balance	



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