



BRAS 3305

Bare Brazing Rods

AWS A/SFA 5.8 BCuP-7

ALLOY BASIS :

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KEY FEATURES:

- Cu-P brazing filler rod with Silver
- Excellent flowing characteristics and high ductility
- No flux is required for copper to copper brazing

TYPICAL APPLICATIONS:

- Brazing of copper tubes, apparatus
- Refrigeration pipes
- Air conditioning pipes
- Motor windings



HEAT SOURCE: Oxy-acetylene torch, Air-Gas Torch, Blow lamp, Furnace, High frequency induction furnace, TIG Process

PROCEDURE :

Remove all scale and oxide from the areas to be joined. Adjust flame to neutral and dip heated rod into the flux. Bring the base metal to melting point and then lower the filler rod into the puddle and allow to melt. When joint is completed, reheat to a dull red and allow to cool slowly.

CLEANING:

Remove Flux residues by rinsing in hot water.

TECHNICAL DATA :

| | Ag | P | Cu |
|---------------|-----------|-----------|---------|
| Specification | 4.8 - 5.2 | 6.5 - 7.0 | Balance |

TECHNICAL DATA :

| Solidus Temperature | Liquidus Temperature | Brazing Temperature Range |
|---------------------|----------------------|---------------------------|
| 643°C | 771°C | 705-815°C |

PACKING DATA:

| Ø x L, mm | Kg/Plastic Tube | |
|------------|-----------------|--|
| 1.60 X 500 | 2 | |
| 2.50 X 500 | 2 | |
| 3.15 X 500 | 2 | |