



**Bare Brazing Rods**  
**BRAS 3305**

COPPER-PHOSPHORUS BRAZING FILLER ROD WITH SILVER CONTENT



**ALLOY BASIS :** AWS A/SFA 5.8

BCuP-7

**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 rising in hot water.

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :**

	<b>Ag</b>	<b>P</b>	<b>Cu</b>
Specification	4.8 - 5.2	6.5 - 7.0	Balance

**TECHNICAL DATA :**

<b>Solidus Temperature</b>	<b>Liquidus Temperature</b>	<b>Brazing Temperature Range</b>
643°C	771°C	705-815°C

**PACKING DATA :**

<b>Ø x L, mm</b>	<b>Kg/Plastic Tube</b>
1.60 X 500	5
2.50 X 500	5
3.15 X 500	5