

Copper Brazing Alloys

相关牌号 Related standard	主要化学成分 Chemical Composition			熔化温度Melting range 固相℃ Solidus℃		用途 Application
	Ag	P	Cu	液相℃ Liquidus℃		
L-CuP6	—	6.0	bal.	710	890	铺展性及填缝性好,适用于各种铜和铜合金。 Good capillary flow and ductibility, Capillary brazing of cooper, brass and bronze, No flux is required for copper
BCu93P	—	6.8-7.5	bal.	710	790	
L-CuP7	—	7.0	bal.	710	790	
BCuP-2		7.0-7.5	bal.	710	793	
BCu92P	—	7.5-8.5	bal.	710	780	
L-CuP8	—	8.0	bal.	710	770	
L-CuSnP7	Sn:6.8-7.2	6.6-7.0	bal.	650	700	适用于空调、冰箱等制冷设备及电机的铜部件,钎焊工艺性能优良。 For brazing copper parts in airconditioners, freezers, refrigerators and motors. The brazing performance is excellent.
BCu91PAg	1.8-2.2	6.8-7.2	bal.	645	788	
BCuP-6	1.8-2.2	6.8-7.2	bal.	645	788	
L-Ag2P	2.0	6.2	bal.	645	825	
BCu89PAg	4.8-5.2	5.8-6.7	bal.	645	815	
BCuP-3	4.8-5.2	5.8-6.2	bal.	645	815	
BCuP-7	4.8-5.2	6.5-7.0	bal.	645	785	
L-Ag5P	5.0	6.0	bal.	645	815	
BCu87PAg	5.8-6.2	7.0-7.5	bal.	645	724	
BCuP-4	5.8-6.2	7.0-7.5	bal.	645	724	
BCu80AgP	14.5-15.5	4.8-5.2	bal.	645	800	
BCuP-5	14.5-15.5	4.8-5.2	bal.	645	800	
L-Ag15P	15.0	5.0	bal.	645	800	
BCu75PAg	17.5-18.5	6.0-6.5	bal.	645	680	
18M	18.0	6.3	bal.	645	680	适用于电机、大型变压设备、眼镜等铜及铜合金件的钎焊。 For brazing copper and copper alloys in motors, transformation equipment and spectacles.
L-Ag18P	18.0	7.05	bal.	645	645	

Silver Brazing Alloys

相当于国外 标准牌号	化学成分(%) Chemical Composition					熔化温度℃ Melting Range		主要特性及适用范围 (Typical Application)
	Ag	Cu	Zn	Cd	其他 Other	固相线 Solidus	液相线 Liquidus	
德国: L-Ag20Cd (Germany)	19 — 20.5	39 — 41	24 — 26	13 — 17		620	765	熔点低, 钎焊性好, 流动性好。适用于钢、铜、铜合金、镍合金的钎焊。 Low melting point, perfect welding ability, excellent fluidity. For brazing steel, copper, copper alloy, nickel alloy.
AWS: BAg-27	24 — 26	29 — 31	26 — 29	16.5 — 18.5		605	720	熔点低, 钎焊性好。适用于钢、铜、铜合金、镍合金的钎焊。 Low melting point, perfect welding ability. For brazing steel, copper, copper alloy, nickel alloy.
AWS: BAg-2a	29 — 31	27 — 29	20 — 22	20 — 22		600	690	熔点低, 钎焊性好, 流动性好。适用于钢、铜、铜合金、镍合金的钎焊。 Low melting point, perfect welding ability, excellent fluidity. For brazing steel, copper, copper alloy, nickel alloy.
AWS: BAg-2	34 — 36	25 — 29	19 — 23.5	17 — 19		605	700	熔点低, 钎焊性好。适用于钢、铜、铜合金、镍合金的钎焊。 Low melting point, perfect welding ability. For brazing steel, copper, copper alloy, nickel alloy.
欧盟: Ag-304	39 — 41	15.5 — 16.5	19 — 23	18 — 22		595	630	熔点低, 钎焊性好, 流动性好。适用于钢、铜、铜合金、镍合金的钎焊。 Low melting point, perfect welding ability, excellent fluidity. For brazing steel, copper, copper alloy, nickel alloy.
AWS: BAg-1	44 — 46	14 — 16	14 — 18	23 — 25		595	620	熔点低, 钎焊性好。适用于钎焊小间隙接头。 Low melting point, excellent fluidity. Suitable for mini gap joints.
AWS: BAg-1a	49 — 51	14.5 — 16.5	14.5 — 18.5	17 — 19		625	635	熔点低, 钎焊性好。适用于钎焊小间隙接头。 Low melting point, excellent fluidity. Suitable for mini gap joints.

SILVER BRAZING FLUXES



White silver brazing flux: (Ultra flux from Wolverine)

AWS A5.8: AWSFB3-A

Fed. Spec O-F-499 Type B

SAE Aeronautic Materials Spec: AMS 3410

Fully molten at 1100F (593C) effective to 1600F (871C)

Packing size: 500gm/jar or 65lbs per pail

SILGLO® Black Flux

AWS A5.8: AWS FB3C

Fed. Spec O-F-499 Type B

SAE Aeronautic Materials Spec: AMS 3410

Effective for brazing for temperatures up to 1800F(982C)

Packing size: 500gm/jar or 65lbs per pail

SILGLO® Dry Flux

For silver brazing allows user to consumers to customize the flux's solvent and viscosity characteristics.

Packing size: 250gm/jar