

## TECHNICAL DATA SHEET

### DULLFOS® 5

#### Phoscopper Brazing alloys, Cadmium Free

EN ISO 17672:2016	CuP 281
AWS A5.8-92	BCuP-3
ISO 3677:1997	
DIN 8513	(L-Ag5P)
(EN 1044:1999)	(CP 104)

#### Nominal Composition [%]

Ag	Cu	P	Sn			
5	89	6	-			

#### Technical Data

Melting Point	c.a. 645 - 815 °C
Working Temperature	c.a. 710 °C
Density	c.a. 8,2 gr/cm <sup>3</sup>
Tensile strength	250 Mpa with Cu
Elongation	c.a. 2%
Electrical Conductivity	n.d. m/ mm <sup>2</sup>



#### Applications

DULLFOS® 5 is a phosphorous containing brazing alloy, very popular, extremely fluid, used for joining copper and copper alloys, brass and bronze. Due to its P content, it is considered self-fluxing, that is no additional flux is required when joining copper to copper. On the contrary, when used with a copper alloy or brass or bronze, a brazing flux is suggested to promote wetting and fluidity on the joints. Typical applications are in refrigeration and air conditioning industry and heat exchanger manufacturers. Do not use when the brazed joint is exposed to Sulphur in their working environment. DULLFOS® 5 thanks to a special production process, guarantee a safe and efficient brazing, free from annoying sparkles and splashes. Even when overheated, the alloy does not bubble, flows smoothly and wets completely the surfaces to be brazed. The result is a joint free from porosity, safer and cleaner, and with enhanced mechanical and pressure tightness properties. It gives the possibility of second step brazing without any event of bubbling.

#### Base Metals

Copper to copper without flux, with flux also brass, bronze, red brass

#### Heat Sources

Manual and induction heating

Bare rods	Fluxcoated	Wire < Ø 1,0	Wire > Ø 1,0	Foil	Extruded bars	Rings
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