

## TECHNICAL DATA SHEET

# DULLFOS 15

## Phoscopper Brazing alloys, Cadmium Free

EN ISO 17672:2016	CuP 284
AWS A5.8-92	BCuP-5
ISO 3677:1997	
DIN 8513	L-Ag15P
(EN 1044:1999)	CP 102

### Nominal Composition [%]

Ag	Cu	P	Sn			
15	85	5	-			

### Technical Data

Melting Point	c.a. 650-800°C
Working Temperature	c.a. 700°C
Density	8,4 gr/cm <sup>3</sup>
Tensile strength	250 Mpa
Elongation	22%
Electrical Conductivity	7,0 m/ mm <sup>2</sup>



### Applications

DULLFOS® 15 is an alloy with high fluidity and penetration, even at low temperatures. Mainly used in copper-copper soldering. Its use with iron or nickel alloys is not recommended. It is widely used in the refrigeration sector, especially when the joint is subjected to strong mechanical or thermal stress. Much appreciated also in electromechanical constructions for its great conductivity. Do not use in sulfur saturated environments. Joint operating temperature between -70° and +150°C.

### Base Metals

Copper alloys, without the use of deoxidizer. Brass and Bronzes.

### Heat Sources

Flame, induction, oven, furnace

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