

TECHNICAL DATA SHEET

FOS 60

Phoscopper Brazing alloys, Cadmium Free

EN ISO 17672:2016	CuP 179
AWS A5.8-92	
ISO 3677:1997	
DIN 8513	(L-CuP6)
(EN 1044:1999)	(CP 203)

Nominal Composition [%]

Ag	Cu	P	Sn			
-	94	6	-			

Technical Data

Melting Point	c.a. 710 - 890 °C
Working Temperature	c.a. 760 °C
Density	c.a. 8,1 gr/cm ³
Tensile strength	250 Mpa (su Rame)
Elongation	n.a.
Electrycal Conductivity	- m/ mm ²



Applications

FOS 60 is a CuP Filler metal similar to FOS 70; but with lower fluidity and higher melting point. FOS 60 has good capillarity and filling properties. It had a wide use in manufacturing of big heat exchanger and air conditioner. It could be support a re-brazing process without loosing its characteristics. Do not use in environmental rich of sulfur and for brazing Ni and Fe alloys. When used for brazing copper to brass, it is suggested the use of specific flux (Flux F Cu) for reducing the formation of intermetallic compounds. Not for application in media containing sulphur. Not for Fe and Ni alloys

Base Metals

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

Heat Sources

It can be used for brazing with flame, with induction heating and in a furnace under

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