

## TECHNICAL DATA SHEET

# SILVERFOS 204

## Phoscopper Brazing alloys, Cadmium Free

EN ISO 17672:2016	-
AWS A5.8-92	-
ISO 3677:1997	B-Cu93P(Ag) - 700/850
DIN 8513	
(EN 1044:1999)	-

### Nominal Composition [%]

Ag	Cu	P	Sn			
0,4	93,6	6	-			

### Technical Data

Melting Point	c.a. 700 - 850 °C
Working Temperature	c.a. 800 °C
Density	c.a. 8,1 gr/cm <sup>3</sup>
Tensile strength	250 Mpa
Elongation	n.a.
Electrycal Conductivity	n.a.



### Applications

SILVERFOS 204 is a self-fluxing alloy on copper; FCu flux otherwise is recommended on copper alloys. It has better fluidity and wetting than FOS 80, with similar melting temperature. It allows a good filling at lower temperatures. The addition of Silver helps in strenght the brazed joint, enhancing its resistance to mechanical vibration or temperature excursion in environment.

### Base Metals

Copper and its alloys. Copper to brass (with flux)

### Heat Surches

Manual Brazing, Induction brazing

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