

TECHNICAL DATA SHEET

SILVERFOS 280

Phoscopper Brazing alloys, Cadmium Free

EN ISO 17672:2016	CuP 280
AWS A5.8-92	BCuP-6
ISO 3677:1997	B-Cu91PAg-643/788
DIN 8513	-
(EN 1044:1999)	-

Nominal Composition [%]

Ag	Cu	P	Sn			
2	91	7	-			

Technical Data

Melting Point	643-788° C
Working Temperature	740° C
Density	8,1
Tensile strength	n.d.
Elongation	n.d.
Electrycal Conductivity	5,5 m/ mm ²



Applications

Silverfos 280 is a silver-copper-phosphorus brazing alloy with excellent flow characteristics. It can be used to join copper with copper-based alloys (eg bronzes / brass). The phosphorus contained in the alloy acts as a flux agent, so it is not necessary to use an additional flux when brazing copper to copper; however, when joining copper based materials (eg bronzes / brasses) a suitable flux must be used. Silverfos 280 should not be used on ferrous or nickel alloys, or alloys containing more than 10% nickel, due to the formation of brittle intermetallic compounds which will cause the joint to fail. Corrosion resistance is generally satisfactory, except when the joint is in contact with sulphurous atmospheres (especially at high temperatures); the alloy must therefore not be used to join parts that could come into contact with fluids containing sulfur. Typical applications are in hydraulics, in the electrical and electromechanical industry, in refrigeration and air conditioning.

Base Metals

Copper - Copper without flux. With flux also brasses and bronzes.

Heat Sources

Flame / Oven / Induction

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