

## TECHNICAL DATA SHEET

### FOS 677

#### Phoscopper Brazing alloys, Cadmium Free

<b>EN ISO 17672:2016</b> <b>AWS A5.8-92</b> <b>ISO 3677:1997</b> <b>DIN 8513</b> <b>(EN 1044:1999)</b>	<b>CuP 386</b> <b>BCup-9</b> <b>B-Cu87PSn-650/700</b>
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#### Nominal Composition [%]

Ag	Cu	P	Sn			
-	86	7	7			

#### Technical Data

<b>Melting Point</b>	c.a. 650 - 700 °C
<b>Working Temperature</b>	c.a. 650 °C
<b>Density</b>	c.a. 8,0 gr/cm <sup>3</sup>
<b>Tensile strength</b>	250 Mpa (su Rame)
<b>Elongation</b>	n.a.
<b>Electrycal Conductivity</b>	99,9 m/ mm <sup>2</sup>



#### Applications

FOS 677 is a CuP alloy with adding of tin that gives it a very good flowing and excellent capillarity. It has a relatively low working temperature, but not self fluxing in air; it demands flux (suggested with Flux FCu). Ideal for furnace brazing! The joints made with Fos 677 on copper and brass (kettle elements, electrical resistance immersion heaters) have good ductility. It is commonly used in heat exchangers production, fittings and HVAC. 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 Surches

Furnace in protected atmosphere

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