

Brazelt-6F (BCup-4)

Nominal Composition:	
Silver	6.00 ± 0.20%
Phosphorous	7.25 ± 0.20%
Copper	Balance
Total other Elements	0.15 % Max
Physical Constants:	
Solidus	1190°F (645°C)
Liquidus	1325°F (720°C)
Brazing Range	1275-1450°F (690-788°C)
Specific Gravity	5.38
Density (lb/cu in)	.294
Electrical Conductivity (% IACS)	7.9
Electrical Resistivity	21.9
Color	Light Copper

DESCRIPTION:

Brazelt-6F is used for the brazing of copper and copper alloys, brass and bronze. Brazelt6F should not be used on ferrous metals or copper alloys containing more than 10% nickel because of phosphorus embrittlement due to reactions with iron or nickel. Brazelt-6F is a midrange silver containing copper phosphorous alloy suitable for wider capillary joint fit up in the range of .003”-.006”. Its melting characteristics are such that it has moderate flow with good filleting and gap filling characteristics when joint fit ups are less than ideal.

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength using Brazelt6F will surpass the strengths of the base metals. Strength is a function of the base metals being joined, type of joint, design of joint, joint clearances and brazing procedures. The recommended maximum operating temperatures for Brazelt6F are 300°F (continuous service) and 400°F (short time service). Corrosion resistance is satisfactory except when the joint is in contact with sulfurous atmosphere (especially at elevated temperatures).

APPLICATIONS:

The phosphorus content of Brazelt-6F acts as a fluxing agent and no flux is necessary when brazing copper joints. However, when used with a copper alloy or one of the other brazeable metals, a brazing flux must be used to promote wetting, bonding, and flow throughout the joint. The flow point of Brazelt-6F is 1275°F (690°C).

SPECIFICATIONS:

AWS A5-8	BCup-4
ASME	BCup-4
QQ-B-650	BCup-4

SAFETY INFORMATION:

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting." For more complete information refer to the Material Safety Data Sheet for Brazelt-6F.

AVAILABLE FORMS:

Standard forms of Brazelt-6F are wire and preforms.