



WELDCOTE 15 BRAZING ALLOY

WELDCOTE 15 is a Phos-Copper brazing alloy formulated to join copper, brass and bronze. This alloy is the standard of the industry for many air conditioning and refrigeration applications as well as electrical. Weldcote brazing flux is needed when working on brazeable grades brass or bronze. Phos-Copper alloys are self-fluxing on copper but should not be used on copper alloys containing more than 10% nickel, steels, and ferrous metals or in any sulfurous atmospheres. Aluminum bronze requires the use of Aluminum bronze brazing flux.

CHEMICAL COMPOSITION, Weight Percent:

Silver	14.5-15.5
Copper	Balance
Phosphorus	4.8-5.2
Total Others Elements	0.15

PHYSICAL DATA:

Solidus	1190°F (643°C)
Liquidus	1475°F (802°C)
Brazing Range	1300-1500°F (704-816°C)
Color	Bright Silver Copper
Specific Gravity	8.44
Density (lb/cu in.)	0.301
Electrical Conductivity (% of IACS)	9.91
Electrical Resistivity (Microhm-cm)	17.38

AVAILABLE SIZES:

20" Rods of 1/16, 3/32, 1/8 and .050 X 1/8

SPECIFICATIONS:

AWS A5.8/A5.8M	BCuP-5
ASME SFA5.8	BCuP-5
FED QQ-B-650C & QQ-B-654A	BCuP-5
FED QQ-B-654 & MIL-B-15395	Grade III

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.