



WELDCOTE 5 BRAZING ALLOY

WELDCOTE 5 is a Phos-Copper brazing alloy formulated to join copper, brass and bronze. This alloy may be used where joint clearance is wider than desired and will fill moderate size gaps. 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	4.8-5.2
Copper	Balance
Phosphorus	5.8-6.2
Total Others Elements	0.15

PHYSICAL DATA:

Solidus	1190°F (643°C)
Liquidus	1495°F (813°C)
Brazing Range	1325-1500°F (718-816°C)
Color	Bright Light Copper
Specific Gravity	8.13
Density (lb/cu in.)	0.293
Electrical Conductivity (% of IACS)	9.6
Electrical Resistivity (Microhm-cm)	18.11

AVAILABLE SIZES:

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

SPECIFICATIONS:

AWS A5.8/A5.8M	BCuP-3
ASME SFA5.8	BCuP-3
FED QQ-B-650C	BCuP-3