

## XP Cu BRAZE 773 (FLUX COATED)

OXY-FUEL BRAZING



### CLASSIFICATIONS

EN ISO 17672	AWS - A5.8
Cu 773	RBCuZn-D

### KEY FEATURES AND APPLICATIONS

- Cu BRAZE 773 is a high strength, corrosion resistant, flux coated brass brazing alloy with addition of nickel.
- Typically used in the joining of steel to steel or carbide to steel.
- Due to the high zinc content, the heating cycle should be minimised to avoid zinc vaporisation.
- Flux/paste not required.
- Typically used in tubular manufacturing for items like metal furniture and bicycle frames etc.

### CHEMICAL COMPOSITION OF WIRE %

	Cu	Zn	Si	Ni
MIN	46.0	Remainder	0.15	9.0
MAX	50.0		0.2	11.0

Single values are maximum values according to EN ISO 17672

### BRAZING TEMPERATURE RANGES

Solidus Melting Temperature	Liquidus Melting Temperature	Recommended Brazing Temperature
890°C	920°C	~940°C

Temperature ranges are not guaranteed since actual as welded conditions depend on numerous variables

### PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP50686	2.5	1000	2.5	PAP 20 Tube
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