

XP CuP BRAZE 279

OXY-FUEL BRAZING



CLASSIFICATIONS

EN ISO 17672

CuP 279

KEY FEATURES AND APPLICATIONS

- CuP BRAZE 279 is a silver-copper-phosphorus brazing alloy.
- Typically used to join copper-to-copper or copper based base materials (e.g. bronze / brass).
- Copper-to-copper joints are self-fluxing due to the phosphorus content.
- Suitable for use with our XP FLUX CU1.
- Commonly used in the refrigeration and air conditioning industries.

CHEMICAL COMPOSITION OF WIRE %

	Cu	P	Ag
MIN	Remainder	5.9	1.5
MAX		6.7	2.5

Single values are maximum values according to EN ISO 17672

BRAZING TEMPERATURE RANGES

Solidus Melting Temperature	Liquidus Melting Temperature	Recommended Brazing Temperature
645°C	825°C	~740°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
XP50655	1.5	500	1	PAP 20 Tube
XP50656	2.0	500	1	PAP 20 Tube
XP50657	2.5	500	1	PAP 20 Tube
XP50658	3.0	500	1	PAP 20 Tube