

## XP CuP BRAZE 284

OXY-FUEL BRAZING



### CLASSIFICATIONS

EN ISO 17672	AWS - A5.8
CuP 284	BCuP-5

### KEY FEATURES AND APPLICATIONS

- CuP BRAZE 284 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	4.8	14.5
MAX		5.2	15.5

Single values are maximum values according to EN ISO 17672

### BRAZING TEMPERATURE RANGES

Solidus Melting Temperature	Liquidus Melting Temperature	Recommended Brazing Temperature
645°C	800°C	~705°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
XP50665	1.5	500	1	PAP 20 Tube
XP50666	2.0	500	1	PAP 20 Tube
XP50667	2.5	500	1	PAP 20 Tube
XP50668	3.0	500	1	PAP 20 Tube