Product Uses
Aufhauser’s Oxygen Free High Conductivity Copper is a filler metal used in the brazing of ferrous and nickel-based alloys. Applicable for brazing steel, stainless steel, and copper-nickel alloys. Best results are produced in a vacuum furnace without the use of flux.

Brazing Characteristics
OFHC flows freely with good wetting characteristics on ferrous and nickel-based materials. Optimum strength and joint integrity are achieved when joint clearance lies between 0.000 in. - 0.001 in. (0.000 – 0.025 mm) per side.

Chemical Composition:
Copper 99.99% min
Impurities, % max

<table>
<thead>
<tr>
<th>Sb</th>
<th>As</th>
<th>Bi</th>
<th>Cd</th>
<th>Fe</th>
<th>Pb</th>
<th>Mn</th>
<th>Ni</th>
<th>O</th>
<th>P</th>
<th>Se</th>
<th>Ag</th>
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</thead>
<tbody>
<tr>
<td>0.0004</td>
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<td>0.00005</td>
<td>0.001</td>
<td>0.0005</td>
<td>0.0003</td>
<td>0.003</td>
<td>0.0025</td>
<td>0.0015</td>
<td>0.0002</td>
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Sn  Zn
0.0002 0.0001

Physical Properties:
Melt point (Solidus = Liquidus): 1981°F (1083°C)
Brazing range: 2000 – 2100°F (1093 – 1149°C)
Specific gravity, g/cm³: 8.94
Density, Lb/inch³: 0.323
Electrical conductivity (% IACS): 101
Electrical resistivity (Microhm-cm): 1.71

Specifications
Aufhauser’s OFHC Copper conforms to:
AWS A5.8M/A5.8 BVCu-1x
ASTM B170 Grade
ASTM F68

Available Forms
Wire, strip, engineered preforms, or preforms per specifications (min. order size applies).

Safety Information
The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, “Safety in Welding and Cutting”. For more complete information refer to the Safety Data Sheet for CDA 101.