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OFHC Copper CDA 101

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

Sb	As	Bi	Cd	Fe	Pb	Mn	Ni	O	P	Se	Ag	S	Te
0.0004	0.0005	0.0001	0.0001	0.001	0.0005	0.00005	0.001	0.0005	0.0003	0.0003	0.0025	0.0015	0.0002
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 (Microohm-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.

