

## PhosCopper 6HP

### ◆ INTRODUCTION

Aufhauser PhosCopper 6HP is very fluid at brazing temperatures and will penetrate joints with small clearances. Best results are obtained with joint clearances of 0.001 to 0.003". Good for automated brazing applications.

### ◆ APPLICATIONS

- Brazing copper and copper alloys, as well as brass, bronze, silver, tungsten and molybdenum.

### ◆ CHEMICAL COMPOSITION

Silver	Phosphorus	Copper	Total other
6.0	7.25	Balance	.15



### ◆ PHYSICAL and MECHANICAL PROPERTIES

Melting Point:	1190°F
Flow Point:	1275°F
Brazing Range:	1275-1450 °F (691-788 °C)
Density:	0.294 lb/cu.in
Color:	Light Copper

### ◆ SPECIFICATIONS MEET or EXCEED

- AWS A5.8 BCuP-4
- ASME BCuP-4
- QQ-B-650B BCuP-4

### ◆ STANDARD SIZES AND DIAMETERS

- Diameters: 1/16", 3/32", 1/8", 3/16", 1/4"
- Sizes: 18", 20", 36" cut lengths
- Forms: Flat, Square, Round

### ◆ PROPERTIES OF BRAZED JOINTS

Generally, the joint strength produced by PhosCopper 6HP will surpass the strengths of the base metals. Strength is a function of the base metals being joined, type of joint, design of joint, joint clearances and brazing procedures. The recommended maximum operating temperatures for PhosCopper 6HP are 300 °F (continuous service) and 400 °F (short time service). Corrosion resistance is satisfactory except when the joint is in contact with sulfurous atmosphere (especially at elevated temperatures).

### ◆ ADDITIONAL INFORMATION

The phosphorus content of PhosCopper 6HP acts as a fluxing agent and no flux is necessary when brazing copper joints. However, when used with a copper alloy or one of the other brazeable metals, Aufhauser SilverFlux must be used to promote wetting, bonding, and flow throughout the joint. The flow point of PhosCopper 6HP is 1275 °F.