

Technical Data Sheet

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Product Name:	armack phosphorous-containing brazing alloy AS2
Standard delivery forms:	wire (1.0 - 1.5 - 2.0 mm Ø) rods (1.0 - 1.5 - 2.0 – 3.0 mm Ø, 500 mm length)
Nominal composition:	Ag 2%; Cu 91,8%; P 6,2%
Permitted impurities max.:	Al 0,001; Bi 0,030; Cd 0,010; P 0,008; Pb 0,025; Zn 0,05
Density:	8,1 g/cm ³
Tensile strength acc.:	approx. 250 MPa with Cu (DIN EN 12797)
Elongation:	ok. 5%
Electrical Conductivity:	ok. 5,0 m/Ωmm ³
Solidus - Likwidus:	650 - 810 °C
Working temperature:	740 °C
Operating temp. of brazed joint:	max. 150 °C (without loss in strength)
Specifications:	DIN 8513 L-Ag2P DIN EN 1044 CP 105 ISO 17672 CuP 279 The brazing alloy does not contain any restricted substances as specified in Directive 2011/65/EU ("RoHS"), including lead, cadmium, mercury, hexavalent chromium, PBBs or PBDEs.
Applications:	Ag2P is a silver-, copper- and phosphorus-based brazing alloy with good flow characteristics. The alloy is cadmium-free. It can be used for joining copper to copper and copper-based materials, such as bronze and brass. The phosphorus contained in the alloy acts as a flux, eliminating the need for an additional flux when brazing copper to copper (self-fluxing alloy). However, when brazing copper alloys, Armack HS Brazing Flux Paste must be used. COPPER-PHOSPHORUS BRAZING ALLOYS MUST NOT BE USED FOR BRAZING STEEL UNDER ANY CIRCUMSTANCES , due to the formation of brittle intermetallic compounds that may result in joint failure. The brazed joint is resistant to corrosion. An exception is an environment containing sulfur compounds, where exposure to high temperatures can cause a significant reduction in corrosion resistance. The brazing process can be carried out using all standard brazing methods, including flame brazing (torch), induction brazing, and furnace brazing. When brazing in an oxidizing atmosphere, the use of a suitable flux is required. Heat the joint uniformly until the brazing alloy applied to the joint edge melts freely and completely fills the joint gap. When using flux, any flux residues must be removed after brazing. The tensile strength of joints made using the Ag2P alloy generally exceeds the strength of the base materials. However, the final strength of the joint depends on factors such as the type of metals being joined, joint design, brazing gap width, and the

correctness of the brazing procedure. Typical applications include plumbing installations, electrical and electromechanical industries, refrigeration, and air-conditioning systems.

Certificate:

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Note:

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Date:

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