

TECHNICAL DATA SHEET

SILVERFOS 15

Phoscopper Brazing alloys, Cadmium Free

EN ISO 17672:2016	CuP 284
AWS A5.8-92	BCuP-5
ISO 3677:1997	
DIN 8513	L-Ag15P
(EN 1044:1999)	CP 102

Nominal Composition [%]

Ag	Cu	P	Sn			
15	80	5	-			

Technical Data

Melting Point	c.a. 650-800°C
Working Temperature	c.a. 700°C
Density	8,4 gr/cm ³
Tensile strength	250 Mpa
Elongation	22%
Electrycal Conductivity	7,0 m/ mm ²



Applications

SILVERFOS 15 is a high silver copper-phosphorus alloy with high silver content and high ductility, even at low temperatures. Suitable for gap brazing of copper and copper alloys. Typical applications are in refrigeration, air conditioning and electric industry. Recommended for joints with strong thermal load and vibrations. Do not use in sulphurous environment and on Fe- and Ni-alloys. Joint-brazing at working temperatures between -70 °C and +150 °C.

Base Metals

Copper to copper without flux, with flux also brass, bronze, red brass.

Heat Sources

induction heating, with flame and in a furnace under protective atmosphere.

Bare rods	Fluxcoated	Wire < Ø 1,0	Wire > Ø 1,0	Foil	Extruded bars	Rings
-	-	X	X	X	X	X