

Technical Datasheet HPW-104Cp

Cadmium free

Norm

DIN EN ISO 17672:2017	CuP 281
DIN EN 1044:1999	CP 104
EN ISO 3677:2016	B-Cu89AgP-645/815
DIN 8513:1979	L-Ag5P

Composition [mass friction %]

Ag	Cu	P
5	89	6

Valid impurity [max. mass friction %]

Al	Bi	Cd	Pb	Zn	Ges.
0,001	0,03	0,01	0,025	0,05	0,25

Technical Specifications

Melting range	645-815 °C
Solidus	645 °C
Liquidus	815 °C
Working temperature	710 °C
Density	8.2 g/cm ³
Tensile strength	250 N/mm ²
Heat resistant	approx. 200 °C

Applications

Copper on copper without flux, gunmetal, brass and copper-tin alloys with flux.
Cannot be used with sulphur-containing media or with iron and nickel alloys.

Delivery forms

Wires	Ø from 0.3 mm to 5.0 mm, available as bunch or on spools
Rods bare	Ø from 1.0 mm to 4.0 mm, in length von 50 mm to 1,000 mm (standard 500 mm)
Rods coated	standard diameter 1.5 mm, 2.0 mm and 3.0 mm; standard 500 mm (available with different thickness of flux)
Bands	from 0.05 mm thickness, maximum width 70 mm
Preforms	made of wires as rings, sections or band components in any shape made of band as discs, shims, blanks, or bent components in any shape
Flux	according to EN 1045 and EN 29454 on request

Other dimensions and forms available on request.