Soudotec **6806** **SILVER ALLOY**

DESCRIPTION

Bare **cadmium-free self-fluxing** rod with a **high capillary action** made up of a copper, **silver (15%)** and phosphorous alloy for brazing copper and copper alloys (brass and bronze).

CLASSIFICATION

AWS A5.8 BCuP-5

CHARACTERISTICS

- **Laser printed identification of AWS code and heat number on each rod**
- Ideal for small fit joints
- Excellent capillary action
- Excellent electrical conductivity
- Self-fluxing alloy for pure copper applications only
- Good ductility
- Good corrosion resistance
- High tensile strength

TYPICAL APPLICATIONS

Refrigeration, plumbing, air conditioning, electricity, copper, brass or bronze connectors, etc.

PROCEDURE

Remove all traces of grease and dirt from the brazing area. Although soldering flux is not required on copper, the flux **Soudotec F060 should be used on brass and bronze**. Heat the joint indirectly until the flux reaches its boiling point, then apply the alloy and braze around it until it flows into the joint. Do not overheat the joint. Remove any flux residue by plunging into lukewarm water. Use a slightly carburizing flame. **Do not use on ferrous metals.**

MECHANICAL PROPERTIES

Tensile strength : 275 MPa (40 000 lb/po^2)

BRAZING PARAMETERS

Diameter:	3.2 mm (1/8")	2.5 mm (3/32")	1.6 mm (1/16")
Bonding temperature:	From 700°C (1292°F)		
Type of flame:	Slightly carburizing		

Also available in shim: **Soudotec SHM 15**.

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Specialized welding alloys and technology. For technical assistance or for ordering :

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