

Brazing Rods Data Sheet



General Construction

All Lawton solder rods conform to HTM 02 Spec

Type of Product

5% Silver Brazing Alloy

Composition

5% Silver

89% Copper

6% Phosphorous

Impurities to BSEN 17672 Group CP

Alloy conforms to: BSEN 17672:2010 CuP104

Melting Range

645 - 815oC

Appearance

Copper coloured metal

Occupational Health Data

TLV

Odour threshold

Silver 0.1mg/m³ as fume

Phosphorous 1mg/m³ as phosphoric acid

Copper 0.2mg/m³ as fume

Working Temperature

710oC

Tensile Strength

600 N/mm²

Hardness (HV)

190

Elongation

7%

Electrical Conductivity

10% I.A.C.S. at 20oC