MIRACLE HILL
CHINA REFRIGERATION

BRAZING ALLOYS
SOLDERS

REFRIGERATION
WELDING APPLICATIONS

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Non-Silver Brazing Alloys

Phos-Copper

BCuP-2 or BCu93P

Description

Non-Silver brazing alloy is a material with the binary alloy of copper-phosphors base, which has good mobility and processing property. It applies to contact welding, gas flame welding, HF brazing and some furnace welding. Phosphor-copper brazing alloy has self-brazability and doesn't need brazing flux.

Application

Contain less phosphors, has better plastic nature, a little higher melting point.

Certificates & Test

CTI

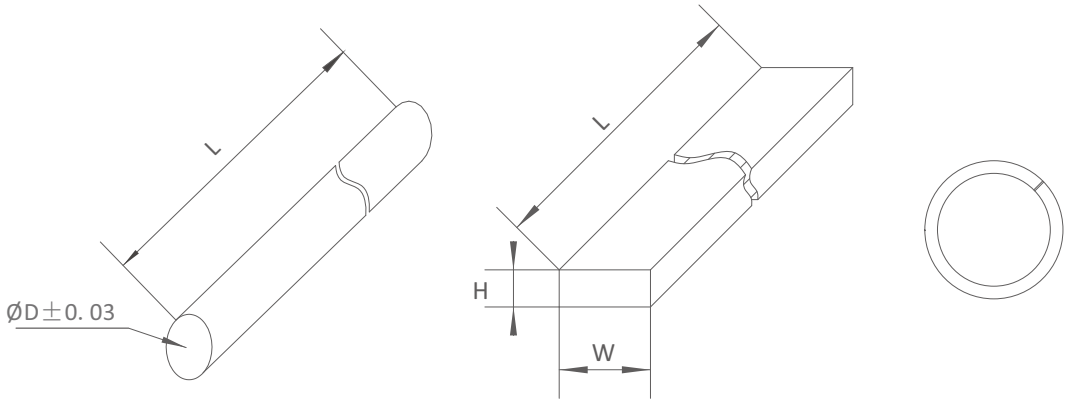
Drawing

NO.: MDBCUP2
DATE:2019-3-1

Dimension(mm)
L=500
W=3.2
H=1.3

Type
Circular
Rectangular
Ring

Other sizes are also available.



Circular Rectangular Ring

Technical Data

Alloy #	AWS A5.8 Standard	Composition	Melting Range		Application
			Solidus °F / °C	Liquidus °F / °C	
BCu93P	BCuP-2	Silver-0% Copper-92.9% Phosphorus-7.1%	1310°F 710°C	1436°F 780°C	Copper and copper alloy parts, refrigeration compressor, not suitable for brazing attacking shocking bend parts.

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Low-Silver Brazing Alloys

Phos-Copper-Silver

BCuP-3, 4,5, 6, 7

Description

Low-Sliver brazing alloy can reduce the melting points, it can improve both the alloys' plasticity and wettability, as well as the alloys' strength and toughness.

Certificates & Test

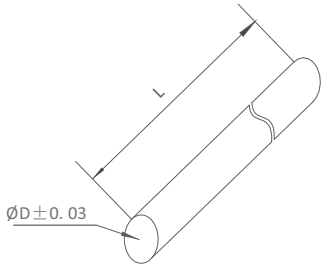
CTI

Drawing

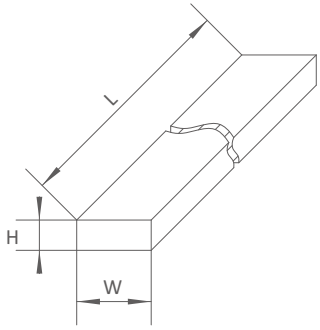
NO.: MDBCUP3
DATE:2019-3-1

Dimension(mm)
L=500
W=3.2
H=1.3

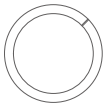
Other sizes are also available.



Circular



Rectangular



Ring

Technical Data

Alloy #	AWS A5.8 Standard	Composition	*Melting Range*		Application
			Solidus °F / °C	Liquidus °F / °C	
BCu89PAg	BCuP-3	Silver-4.8% Copper-remainder Phosphorus-6.6%	1189°F 643°C	1445°F 785°C	Air condition and freezer, copper alloy tie-in electric motor.
BCu87PAg	BCuP-4	Silver-6% Copper-remainder Phosphorus-7%	1193°F 645°C	1336°F 724°C	Low P content suitable for ample clearance, high P content suitable for gap tie-in.
BCu80PAg	BCuP-5	Silver-14.5% Copper-remainder Phosphorus-5%	1193°F 645°C	1472°F 800°C	Copper and copper parts in air condition, freezer, compressor, electric motor
BCu91PAg	BCuP-6	Silver-2% Copper-remainder Phosphorus-7%	1193°F 645°C	1454°F 790°C	Medium gap tie-in
BCu88PAg	BCuP-7	Silver-4.6% Copper-remainder Phosphorus-7%	1193°F 645°C	1409°F 765°C	Air condition and freezer, copper alloy tie-in electric motor.

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High-Silver Brazing Alloys

Silver-Copper-Zinc

BAg-5
BAg-6
BAg-20

Description

High-Sliver brazing alloy is a structure alloy based on silver or silver-base solid solution. Our material can be used to braze all ferrous metals and non-ferrous metals except Aluminum, Magnesium and other metals of low melting point.

The alloys are usually added zinc, stannum, nickel to form ternary or multi-element alloys in order to lower solders' melting point and reduce cost. For example, adding nickel to the silver-based brazing alloys can imporve its heat resistance property, corrosion resistance property and wetting ability.

Certificates & Test

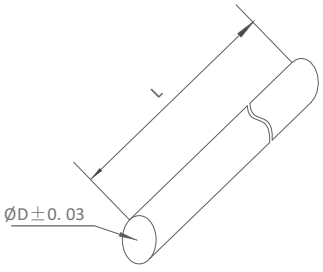
CTI

Drawing

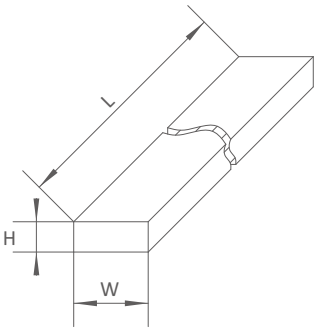
NO.: MDBAG5
DATE:2019-3-1

Dimension(mm)
L=500
W=3.2
H=1.3

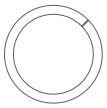
Other sizes are also available.



Circular



Rectangular


Ring

Technical Data

Alloy #	AWS A5.8 Standard	Composition	Melting Range		Application
			Solidus °F / °C	Liquidus °F / °C	
BAg45CuZn	BAg-5	Silver-43% Copper-30% Zn-27%	1229°F 665°C	1373°F 745°C	Electrical, motor, electrical pats, dairy, food industry, steel, copper, copper ally brazing
BAg50CuZn	BAg-6	Silver-50% Copper-35% Zn-15%	1274°F 690°C	1427°F 775°C	Electrical, dairy, food industry, steel, copper, copper alloy brazing
BAg30CuZn	BAg-20	Silver-30% Copper-38% Zn-32%	1250°F 677°C	1410°F 766°C	Steel, stainless steel, copper alloy and the other non-ferrous metals brazing

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High-Silver Brazing Alloys

Silver-Copper-Zinc-Tin

BAg-7
BAg-24

Description

Sliver-Copper-Zinc-Tin brazing alloy is made by adding Sn (stannum) to silver-copper-zinc brazing alloy, can reduce melting point and improve plasticity. It has low melting point property and has good wetting ability and gap filling ability. Besides, with bright and clean brazing seam surface and intensive joint, applies to brazing materials of lower temperature. When brazing, it has no cadmium pollution.

Certificates & Test

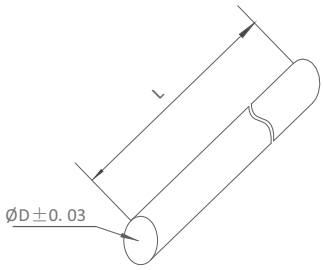
CTI

Drawing

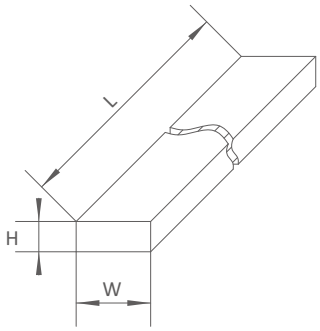
NO.: MDBAG24
DATE:2019-3-1

Dimension(mm)
L=500
W=3.2
H=1.3

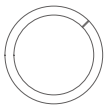
Other sizes are also available.



Circular



Rectangular


Ring

Technical Data

Alloy #	AWS A5.8 Standard	Composition	*Melting Range*		Application
			Solidus °F / °C	Liquidus °F / °C	
BAg56CuZnSn	BAg-7	Silver-55% Copper-23% Zn-17% Sn-5%	1148°F 620°C	1202°F 650°C	Mainly used in stainless steel for food industry brazing
BAg50CuZn (Ni)	BAg-24	Silver-50% Copper-20% Zn-28% Ni-2%	1220°F 660°C	1301°F 705°C	Steel, stainless steel, copper alloy brazing

Cantact us for other alloys,
silver-copper-zinc-indium; silver-copper-zinc-cadmium;
flux coated silver-copper, copper-zinc, aluminum base

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