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TECHNICAL DATA SHEET

DULLFOS® 70

Phoscopper Brazing alloys, Cadmium Free

EN ISO 17672:2016	CuP 180
AWS A5.8-92	BCuP-2
ISO 3677:1997	
DIN 8513	*L-CuP7*
(EN 1044:1999)	*CP 101*

Nominal Composition [%]

Ag	Cu	P	Sn			
-	93	7	-			

Technical Data

Melting Point	c.a. 710 - 820 °C
Working Temperature	c.a. 730 °C
Density	8,1 gr/cm3
Tensile strength	-
Elongation	-
Electrycal Conductivity	- m/Ωmm²

Applications

DULLFOS 70 is a filler metal developed for the heat exchanger and refrigeration manufacturers. It ensures a perfect joint without any leaks and porosity when the clearance of the joints are more than 0,35 mm.
It's a phosphorous content brazing alloy used for joining copper and copper alloys, brass and bronze. Due to its P content, it is considered self-fluxing, that is no additional flux is required when joining copper to copper. On the contrary, when used with a copper alloy or brass or bronze, a brazing flux is suggested to promote wetting and fluidity on the joints.
DULLFOS 70 guarantees a safe and efficient brazing, without sparkles and splashes. This alloy does not bubble when overheated and it flows smoothly, wetting completely the surfaces. The joint will result clean, free of porosity and with enhanced mechanical properties.
Not for application in media containing sulphur, not for Fe and Ni alloys.

Base Metals

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

Heat Sourches

Manual and induction brazing.

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