Soudotec 6800, 6804, 6805, 6806

SILVER ALLOY

DESCRIPTION

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

CHARACTERISTICS

- **Individually laser printed**
- **Identification of AWS code on each rod**
- Ideal for large to tight-fitting 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

6800	0% Silver	AWS BCuP-2	Tensile strength :	40 000 psi (275 MPa)
6804	2% Silver	AWS BCuP-6	Tensile strength :	40 000 psi (275 MPa)
6805	5% Silver	AWS BCuP-3	Tensile strength :	40 000 psi (275 MPa)
6806	15% Silver	AWS BCuP-5	Tensile strength :	45 000 psi (310 MPa)

BRAZING PARAMETERS

Diameter:	3.2 mm (1/8")	2.5 mm (3/32'')	1.6 mm (1/16")
Bonding temperature:	1300 - 1520℉ (705 - 826℃)		
Type of flame:	Slightly carburizing		

Rév. : 7_01

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

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