



Tube to Tube Sheet Joining

## Brazing alloy for copper to copper joints with self fluxing property.

### Typical Applications:

Electric motor repairs, armatures, air conditioning and refrigeration tubing.

### Outstanding Features:

- Low melting brazing alloy.
- Strong, ductile, leak-proof joints.
- Silver-bearing; thin flowing.
- Good corrosion resistance.
- Self fluxing for copper to copper brazing.

### Recommendation:

For production brazing of lap, flange and 'T' joints of copper, brass & bronze metals. The alloy displays good capillary properties, to enable satisfactory flow & penetration even in narrow corners or areas. The alloy is 'self-fluxing' for copper to copper joints. Use of EWACFLUX E10 is recommended for brazing of copper alloys such as brass or bronze. This alloy is not recommended for brazing of ferrous or nickel alloys.

### Procedure:

Clean the surface. Jigs or fixtures are recommended for good fit and proper clearance. Flux is not required for copper to copper brazing. For brazing of copper based alloys (i. e. brass or bronze). Use EWACFLUX E10. Heat the entire assembly evenly, until copper turns dull red in colour or the flux, if used, liquefies. At this stage, melt off a drop of alloy from the rod and flow it into the joint. Repeat this, until the joint is completed.

### Size:

Size (mm)
1.6
3.15

**Bonding Temperature:** 650°C

**Tensile Strength:** 37 Kg/mm<sup>2</sup>  
(52,000 psi)