



# TECHNICAL INFORMATION SHEET

## LCuP-7 BRAZING FILLER METAL

### CHEMICAL COMPOSITION % (Single values are maximum):

Phosphorus	7.1 -7.4
Copper	Remainder
Aluminum	0.01
Bismuth	0.030
Cadmium	0.010
Lead	0.025
Zinc	0.05
Others, (total)	0.25

### TYPICAL PHYSICAL PROPERTIES

Solidus	1310°F (710°C)
Liquidus	1450°F (788°C)
Specific Gravity	8.21

### BRAZING PROPERTIES:

An economical brazing filler metal (very fluid medium temperature brazing alloy) for joining copper, brass, and bronze. Will stand moderate vibration. Recommended joint clearance is .002"-.005". LCuP-7, (and other phosphorus containing filler metals), should not be used to braze ferrous or nickel alloy base metals.

### FLUX:

No flux is required for copper brazing. For brazing brass or copper to brass use Stay-Silv® white flux. Harris ECO SMART® boric acid free flux, (powder or paste), is an excellent choice to promote sound brazed assemblies and comply with European REACH requirements

### CORROSION RESISTANCE

Generally similar to the copper base metal, but phosphorus containing alloys, including LCuP-7, should not be used if the braze is exposed to sulfur or sulfur compounds in service

### AVAILABLE FORMS

Standard wire diameters, coils, rods and preform rings.

### SPECIFICATION COMPLIANCE:

ISO 17672 CuP 180, ISO 17672 CuP 181

### SAFETY INFORMATION:

**WARNING: PROTECT yourself and others. Read and understand this information.**

**FUMES AND GASES** can be hazardous to your health.

**HEAT RAYS, (infrared radiation)** from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

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### THE HARRIS PRODUCTS GROUP

A LINCOLN ELECTRIC COMPANY

4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)