

502 SSK Copper Paste

NOMINAL COMPOSITION

Copper 99.00% Min

PASTE SPECIFICATION

Alloy Content 80 – 85% Nominal
Color Copper
Melting Point (Solidus) 1981°F (1083°C)
Flow Point (Liquidus) 1981°F (1083°C)
Brazing Temperature Range 2000°F - 2100°F (1093°C - 1149°C)

⁽¹⁾ Viscosity is measured at 75°F using Brookfield viscometer, model RVT, #7 spindle, at 20 rpm.

PRODUCT USES

502 SSK Copper Paste is a clean burning, fluxless system for brazing steel and/or stainless steel in high nitrogen, low hydrogen content base atmospheres. This paste can be dispensed through standard dispensing equipment.

COPPER POWDER PARTICLE SIZE DISTRIBUTION AND DENSITY

Particle Size -200 Mesh

PROPERTIES OF BRAZED JOINTS

The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design, metallurgical interaction between the base metal and the filler metal. Joint clearances of 0.000 in (0 mm) - 0.002 in (0.051 mm) per side are optimum for achieving highest joint strength. Joints with increased clearances can still produce adequate joint strengths depending on final operating conditions.

AVAILABLE PACKAGING

502 SSK copper paste is available in various size syringes, jars and cartridges.

SPECIFICATIONS

Copper powder chemistry is manufactured in accordance to the following specifications:

- American Welding Society (AWS) A5.8 BCu-1a
- Society of Automotive Engineers (SAE) / Aerospace Material Specification (AMS) 3430C Type 2

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 84-360/60-112/85C1

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for 502 SSK Copper Paste.

WARRANTY CLAUSE

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