

Copper-Nickel Brazing Paste X6580/40-009/80C1

NOMINAL COMPOSITION

Copper	99.5% Min
Nickel	0.50% Min
Hydrogen Loss	0.30% Max.
Total Other Elements	0.30% Max.

PASTE SPECIFICATION

Binder Content	20.0% Nominal
Alloy Content	80.0% Nominal
Viscosity ⁽¹⁾	380,000 – 440,000 Centipoise
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, #Te spindle, at 2.5 rpm.

GENERAL DESCRIPTION

X6580 copper-nickel paste is a clean burning, fluxless system for brazing stainless steel in a vacuum furnace. This paste can be dispensed through standard dispensing equipment. This product offers excellent vertical slump characteristics. The paste deposit will remain in place and will not spatter during the initial phase of heating. It dries slowly and will not flake off the parts prior to heating allowing for pre-pasting of components several hours before brazing.

COPPER POWDER PARTICLE SIZE DISTRIBUTION AND DENSITY

Particle Size	-200 Mesh
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WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Brazing and Soldering Paste products for 90 days from the date of shipment if stored in the original unopened container. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry. It is recommended that the paste products are stored away from direct heat. Paste may require mixing to regain a homogenous mixture before application.

The 90 day warranty should not be interpreted as the shelf or useful life of the product. The paste products may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

SPECIFICATIONS

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

- American Welding Society (AWS) A5.8/A5.8M BCu-1a
- Society of Automotive Engineers (SAE) / Aerospace Material Specification (AMS) 4740

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: X6580/40-009/80C1 (84-356/40-009/80C1).

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 Copper-Nickel Brazing Paste.

WARRANTY CLAUSE

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