

ARCTEC® PCO 105 BRAZING ALLOY



GENERAL CHARACTERISTICS:

ARCTEC® PCO 105 is a very fluid, economical, silver bearing phosphor copper brazing alloy. It is used primarily for those applications where close joint fit cannot be maintained and has the ability to form fillets without adversely affecting strength. This alloy has self-fluxing properties when used on copper; however, a flux is recommended when used on other metals including alloys of copper.

APPLICATIONS:

ARCTEC® PCO 105 is used as a joining alloy on copper, copper to brass and bronze. Used for refrigeration piping, instrumentation and electrical applications.

WELDING PROCEDURE:

Clean the weld zone free of all contaminants such as rust, grease, oil mill scale, etc., Allow a joint clearance of .003 to .005". Using a neutral flame heat joint area to a dull red heat. Apply alloy directly to joint area. Keeping torch in constant motion continue adding alloy until joint is complete. Be careful not to overheat and do not re-melt. Copper color may be restored by quick immersion in a 10% sulfuric acid solution.

MECHANICAL PROPERTIES:

Tensile Strength: 40,000 psi (275 Mpa)

* Please Note: Tensile strengths shown are approximations only. Tensile strength of brazing alloys are subject to several variables such as procedure used, material being soldered, joint design, fit up, etc., which will all affect the joint strength.

OPERATING PARAMETERS:

WELDING PROCESS; TB

Use neutral flame for brazing.

Brazing Range
1325 to 1500°F 718 to 816°C

Available diameters:	Inch.	1/16	3/32	1/8"
	mm.	1.60	2.50	3.25

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