



a quality welding alloy

ARCtec® PCO HP BRAZING ALLOY

Conforms to: AWS A5.8/A5.8M:2004 BCuP-2

GENERAL CHARACTERISTICS:

ARCtec® PCO HP is a phosphor copper brazing alloy. It is very effective for joining tight fitting copper pipe and tubing. PCO HP is very fluid at brazing temperatures and will penetrate with very little clearance. 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 HP is primarily used as a joining alloy for copper to copper applications. 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 .001 to .003". 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.

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
1350 to 1550°F 732 to 843°C

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

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Subject to change without notice

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