



# BRAS 3314

Bare Brazing Rods

### ALLOY BASIS :

Cu, Ag, P

### KEY FEATURES:

- Cu-P brazing filler rod with 14% Silver
- Excellent flowing characteristics and high ductility
- No flux is required for copper to copper brazing
- For copper alloys use of flux is necessary

### TYPICAL APPLICATIONS:

- Brazing of copper to copper for construction of apparatus
- Copper pipes, Heat exchangers
- Electric motors, Refrigeration pipes
- Joints subjected to very low temperatures



**HEAT SOURCE:** Oxy-acetylene torch, Air-gas torch, Blow lamp, Furnace, High frequency induction furnace, TIG process

### PROCEDURE :

Remove all scale and oxide from the areas to be joined. Adjust flame to neutral and dip heated rod into the flux. Bring the base metal to melting point and then lower the filler rod into the puddle and allow to melt. When joint is completed, reheat to a dull red and allow to cool slowly.

### CLEANING:

Remove Flux residues by rinsing in hot water.

### TECHNICAL DATA :

Solidus Temperature	Liquidus Temperature	Brazing Temperature Range
607°C	618°C	620-760°C

### PACKING DATA:

Ø x L, mm	Kg/Plastic Tube
1.60 X 500	2
2.50 X 500	2
3.15 X 500	2