

## Copper Brazing Paste HF462/60-112/80C1

### ***NOMINAL COMPOSITION***

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Copper	99.00% Min
Total Other Elements	0.30% Max.

### ***PASTE SPECIFICATION***

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Binder Content	20.0% Nominal
Alloy Content	80.0% Nominal
Viscosity <sup>(1)</sup>	30,000 – 50,000 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)
Apparent Density (Lbs /Gallon)	27

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

### ***GENERAL DESCRIPTION***

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Handy Flo 462 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. 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***

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Powder Density (g/cc)	2.7 – 3.0
Particle Distribution	-200 Mesh +325 Mesh 20% Maximum

### ***WARRANTY & STORAGE***

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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***

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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) 4740D
- Society of Automotive Engineers (SAE) / Aerospace Material Specification (AMS) 3430D TYPE 2

## ***APPLICABLE PRODUCT CODE(S)***

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The applicable Lucas-Milhaupt product code(s) for this technical data sheet: HF462/60-112/80C1.

## ***SAFETY INFORMATION***

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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 Brazing Paste.

## ***WARRANTY CLAUSE***

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