

# Lastek 39

## No flux on pure copper

### CLASSIFICATION

EN 1044 : CP 104 // CuPAg 5 BP

AWS A5.8 : B Cu-P3

### GENERAL DESCRIPTION

Silver solder for joining copper and silver without using a flux.

Requires no finishing after brazing (no flux residues that have to be removed).

Lastek 39 cannot be used on nickel or aluminium containing alloys or on steel.

### APPLICATIONS

Joining copper in electrical motors, tubes, ...

Refrigeration industry, heating installations, breweries, dairy farms, car radiators, water pipes in the building industry.

Don't use Lastek 39 for joining copper tubes that contain sulphuric products.

Hardness: ca. 180 HB

Bonding temperature: 680°C (1256°F)

Electrical resistivity: 0.20 ohm.mm<sup>2</sup>/m

### CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

<b>P :</b> 5.70 - 6.30	<b>Ag :</b> 4.50 - 5.50	<b>Cu :</b> Balance		
------------------------	-------------------------	---------------------	--	--

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 250 MPa	≥ 5%	

### GENERAL INFORMATION

**Welding positions** PA, PB

**Shielding gas** NA

**Packing** 1 kg in a cardboard box

**Polarity** NA

**Diameter (mm)** 2.0 3.0

**Length (mm)** 500 500

#### Tips & tricks

Joint clearance: ± 0.5mm (0.02").

Flux (on brass and bronze): Lastek 31C and Lastek 31CH (powders) - Lastek 31CN (paste).

Preheat with a slightly carburizing flame.

Melt the rod without flux on pure copper.

Bonding temperature: 680°C (1256°F)

Electrical resistivity: 0.20 ohm.mm<sup>2</sup>/m

*The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.*