

COMWELD SBA 115

PRODUCT DATA SHEET

**LOW SILVER, CADMIUM FREE
SILVER BRAZING ALLOY**

**705
°C**



SOLDERS & FLUXES

COMWELD SBA 115

- Low Silver, Cadmium free silver brazing alloy.
- Alloy group 1: Silver, Copper, Phosphorous self fluxing alloys for brazing of copper to copper alloys.
- Not suitable for Ferrous metals.
- Use with flux on copper alloys.

CLASSIFICATIONS:

AS 1167.1:	B4
AWS/ASME-SFA A5.8:	BCuP-5
End Tip Colour	TAN

TYPICAL WIRE ANALYSIS:

Ag:	15.0%
Cu:	79.9%
P:	5.0%
Cd*:	0.05%
Zn*:	0.05%

*Cadmium and Zinc may be present only as trace element impurities.

TECHNICAL DATA:

Silver content:	15%
Typical melting range (°C):	645-700
Brazing temp. for complete fluidity:	705°C

DESCRIPTION AND APPLICATIONS:

COMWELD SBA 115 has the best high shear strength combined with the lowest operating temperatures for flux free brazing of copper and copper alloys. SBA 115 lacks the capillary penetration exhibited by the higher phosphorous alloys. Used on hot water tanks, copper tubing and plumbing, etc.

PACKAGING & OPERATING DATA:

AAC (50 O.C.V.), DC+ or DC- polarity.

ROD SIZE (MM)	PACK WEIGHT / TYPE	PACK SIZE	PART NO.
2.4 x 750	Standard Pack	1kg	320505
2.5 x x 500	Blister Pack	5 Rods	322004

SILVER BRAZING FLUX IF REQUIRED:

GP silver brazing flux.

APPROX NUMBER RODS PER KG:

- ø 2.4mm x 500mm = 49
- ø 2.4mm x 750mm = 32
- ø 3.2mm x 750mm = 22