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TW-2P
(AWS BCuP-6)

This alloy combines a few properties of TW-0 and TW-5P. It is capable of filling larger joints at the lowest application temperature range, and flows more at the highest application temperature range. Recommended for joint clearances of 0.05 to 0.13 mm.

APPLICATIONS:

Used for copper and its alloys. This brazing alloy has excellent fluidity within its working temperature and therefore easily penetrates tight-fitting joints (clearance between 0.03 and 0.08mm). Self-fluxing on copper but requires the use of flux when joining brass. Recommended for copper-to-copper that are not subject to vibrations. Use for joining and repairing copper pipes, cooling coils, heat exchangers, refrigeration units and electrical contacts.

CHARACTERISTICS:

Melting Range	:	Solidus 710°C / Liquidus 793°C
Working Temperature	:	730 - 840°C
Heating Method	:	Torch, Furnace, Induction
Tensile Strength	:	25 kg/mm² (35,550 psi)
Elongation in 2”	:	5%
Chemical Composition	:	Cu 91%, P 7%, Ag 2%

PROCEDURE:

Clean brazing area. Use neutral flame. Flux is not needed to join copper to copper. Heat the copper properly until it is a dark red, then add a drop of alloy making it flow. Continue applying the alloy by heating the joint area until it flows completely throughout the joint by capilary action, filling the joint. For joining brass, cover the area well with flux and heat with the torch until the flux liquefies. Apply the alloy. It is very important that the joint is properly closed to ensure leak-free joints, particularly in overlapping joints of copper pipes.

AVAILABLE FORMS:

Round rods (Ø)	:	1/16” (1.6 mm), 3/32” (2.4 mm), 1/8” (3.2 mm)
Flat Rods	:	0.05” x 1/8” (1.3 x 3.2 mm)
Lengths	:	18” (457 mm), 20” (508 mm) and 500 mm