

Lastek 391

Copper pipes

CLASSIFICATION

EN ISO 17672 : CuP 179

AWS A5.8 : B Cu-P6

GENERAL DESCRIPTION

Brazing alloy on the basis of copper for the connection of copper, brass and bronze.

Lastek 391 is especially recommended where careful preparation of the joint is not possible (large or unevenly shaped gaps, overhead welding, ...).

The melting characteristics are such that the operator has complete control of the weld pool.

On red copper Lastek 391 can be used without flux.

For brass, cast copper, tin-copper alloys: use flux.

APPLICATIONS

Recommended for cold and hot water systems, cooling systems, sanitary and electrical applications.

Not suitable for gas pipes or for soldering steel. Here you can use Lastek 31, Lastek 32, Lastek 34, ...

For joints that are subject to fatigue (e.g. cable connections on vibrating transformers, rotating electric motors, etc.), the use of Lastek 38 or Lastek 39 is recommended above Lastek 391.

Bonding temperature: 690 °C (1274 °F)

Electrical resistivity: 0.25 ohm.mm²/m

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

P : 5.90 - 6.50	Cu : Balance			

MECHANICAL PROPERTIES (Typical values, all weld metal)

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

GENERAL INFORMATION

Welding positions NA

Shielding gas NA

Packing 5 kg in a cardboard box

Polarity NA

Diameter (mm) 2.0 3.0

Length (mm) 500 500

Tips & tricks

Flux: Lastek 31CH (powders) - Lastek 31CN (paste).

Preheat with a slightly carburizing flame.

If the solder does not run around in the seam by itself, then add at different places.

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.