



**!!!! WARNING !!!!**



**WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.**

**BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND MATERIAL SAFETY DATA SHEET (MSDS).**

**THE MATERIAL SAFETY DATA SHEET (MSDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE MSDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.**

**DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) AND PRODUCT WARNING STATEMENT.**

**BE SURE TO CONSULT THE LATEST VERSION OF THE MSDS.**

**SEE THE PRODUCT WARNING LABEL AND MSDS FOR COMPLETE WARNING INFORMATION.**



# **CROWN ALLOYS** **COMPANY**

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## **Crown Sil-Cop 15**

**Brazing Alloy for Copper, Brass and Bronze  
For Torch Application**

### **Typical Applications:**

**Crown Sil-Cop 15** is a self-fluxing brazing alloy for copper to copper joints. The phosphorus content serves as the self-fluxing agent when joining copper to copper. The **Crown Sil-Cop 15** is **NOT** recommended for brazing steel, nickel or stainless steel. **Crown Sil-Cop 15** **can** be used on brass or bronze with the **Crown 45 Flux**.

The **Crown Sil-Cop 15** is excellent for situations in which close fit-up does not exist and where agitation and vibration in service are involved. It is recommended for joint clearances of 0.002 to 0.005 inches. The **Crown Sil-Cop 15** is used predominantly in the air conditioning and refrigeration industries. It is often used on electrical motors and hot water copper pipes where vibration is extreme.

### **Specifications:**

AWS A 5.8

BCuP-5

Phosphorous	4.8-5.2
Silver	14.5-15.5
Copper	Balance
Others	0.15 max

➤ Liquidus	1465°F ± 10°F
➤ Solidus	1190°F
➤ Brazing Range	1300°F-1500°F
➤ Tensile Strength	86,000 PSI
➤ Elongation	26%

### **Procedure:**

Clean joint area. Use **Crown 45 Flux** on brass and bronze parts. Use a large tip. Heat broadly until copper sweats or flux liquefies. Apply sufficient alloy to fill joint.

### **Sizes:**

1/16 x 36"

3/32 x 36"

1/8 x .050 x 18"

1/8 x 36"

### **Part Number:**

LSCOP15/TL

LSCOP15/TN

LSCOP15/TI

LSCOP15/TO