



*To be Global leader of Welding Materials!*

# Xinxiang Qixing Welding Material Co.,Ltd.

## Company Profile

Xinxiang Qixing Welding Material Co., Ltd, started in the 1980's, our company is located in the middle of China, factory area is 30,000 square meters, including more than 9,000 square meters workshop. We are the most professional producer on welding materials. As the member of China Welding Association, we focus on brazing materials development and production, dedicated to create the most excellent brand of welding material in the world.

We mainly produce "Qixing" brand of copper-based, silver-based, aluminum-based brazing materials, and all of our products meet SGS and RoHS directive requirements. We supply welding rod, welding wire, welding ring, flat wire, wire coils and kinds of brazing materials with different size and figure. Now our production capacity is 450 tons/month for brazing rod, and for Phos-Copper alloys, that is about 220 tons/month. In our field, now we are the No.1 in China.

Now our products have already been widely used in refrigeration, refrigerators, air-conditioner, aerospace, nuclear power system, electric appliances, drilling and excavation, and jewelry, etc. With excellent quality and service, currently we take more than 90% marketing shares in Chinese after-sales service market, and cooperate with many famous companies, such as Midea, Gree, LG, Hisense, Haier, Aux and so on; we also export our products to Middle East, Southeast Asia, Central Asia, Europe, North America and other regions and countries.

We always promise "best quality, best service!" Keep strive to make "QIXING" brand brazing materials to be the most welcomed products in China and all over the world! To be Global leader of Welding Materials!



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## Phos-Copper-Silver Brazing Alloy (Low-silver solder)

### 1. Introduction

Phos-Copper-Silver Brazing Alloy can reduce melting point, improve plasticity of brazing alloy and wettability of copper, as well as brazing alloy's strength and toughness.

### 2. Technical Index

Alloy	Corresponding Alloy	Chemical Composition			Melting Range		Impurity Amount	Main Features	Typical Application
		Ag %	Cu %	P%	Solidus °C	liquidus °C			
BCu92PAg	Ministry standard : L203 JP: COPsilos-1	0.8-1.2	REM	6.8-7.2	643	796	≤0.15	Solidus curve is lower than Cu-P brazing alloys, better wettability, strength and toughness	Use for brazing copper and copper alloy parts.
BCu91PAg	Ministry standard : L209 TC-312 AWS: BCuP-6	1.8-2.2	REM	6.8-7.2	643	788	≤0.15	Good flow-strength, good solderability and plastic nature, better strength	Use for brazing copper and copper pairs in refrigerator and air conditioner, suitable for medium gap joints.
BCu90PAg		2.8-3.2	REM	6.8-7.2	645	780	≤0.15	Better strength, liquidus is high because of containing for P.	Use for copper and copper alloy parts, suitable for large gap joints.
BCu88PAg	JP: TC-315 AWS: BCuP-7	4.8-5.2	REM	6.5-7.0	643	771	≤0.15	Along with increasing of Ag contents, strength will be better.	Use for copper and copper, copper and brass parts with shake in air conditioner and freezer, copper and copper alloy joints in electric motor and meter. Low phosphorus content suitable for brazing large gap joints; with high phosphorus content suitable



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									for brazing small gap joints..
BCu89PAg	Ministry standard : L205 AWS: BCuP-3	4.8-5.2	REM	5.8-6.2	645	815	≤0.15	Along with increasing of Ag contents, strength will be better.	Use for copper and copper, copper and brass parts with shake in air conditioner and freezer, copper and copper alloy joints in electric motor and meter. Low phosphorus content suitable for brazing large gap joints; with high phosphorus content suitable for brazing small gap joints..
BCu87PAg	AWS: BCuP-4	5.8 - 6.2	REM	7.0-7.5	643	813	≤0.15	Good flow-ability, good solderability, can instead JAgP-15 (204)	Low P content suitable for large gap joints, high P content suitable for small gap joints, suitable for brazing flat wire on spectacle frames, suitable for resistance welding.
BCu84PAg		9.0-11. 0	REM	5.5 - 6.5	645	790	≤0.15	Good fluidity, good brazing toughness	Can be made into flat wire, brazing copper and copper alloy in spectacle frame
BCu80PAg	Ministry standard :L204	14.5-1 5.5	REM	4.8-5.2	645	800	≤0.15	Good flow-ability	Suitable for brazing copper and copper alloy medium gap joints on air conditioner, refrigerator, compressor and motor

**Note:** 1, P: phosphorus; AG: Silver; Cu: copper;  
 2, CWA: China welding association; AWS: America welding Society; Russia:(unknown)  
 3, REM: Remain;  
 4,ERW: Electric Resistance Welding

### 3. specification

Welding rod : diameter:0.8mm-5.0mm length: 450mm-1000mm

Website:[www.brazing-rod.com](http://www.brazing-rod.com)



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Welding ring : Opening tolerance: $\leq 0.3\text{mm}$  Inner tolerance: $\leq +0.08\text{mm}/-0.07\text{mm}$

Flatness tolerance: $\leq 0.10\text{mm}$

Flat wire:

size: $0.1\text{mm}-0.2\text{mm} \times 1\text{mm}-2\text{mm}$

Tolerance: $\pm 0.05\text{mm}$

## 4. FAQ

1. Which products are your best selling products ?

Our best selling products are : Phos-Copper Brazing Alloys , Silver based Brazing alloys, Brass Brazing alloys Note : free sample is supplied .

2. Can you provide customized products & marked on the rods ?

Yes . We have professional R & D department, if you have any special needs on products, just contact us for best cooperation. We also can mark your logo on the rod according to your demands .

3. What is the purpose of our company ?

Our company purpose is “ make high-quality goods for customers, create value for employees , provide wealth for the society ! ” And our faith is “independent innovation, scientific development ! ” we always promise “ best quality, best service ! ” Keep strive to make " QIXING " brand brazing filler metal to be the most welcomed products in China and the whole world! Welcome partners to join us develop more and more business all over the world. To be Global leader of Welding Materials !

## 5. Mainly Product :

- 1 . Phos-Copper Brazing Alloy(No Silver Solder)
- 2 . Phos-Copper-Silver Brazing Alloy (Low-silver solder)
- 3 . Silver-Copper-Zinc Brazing Alloy(High-silver solder)
- 4 . Silver-Copper-Zinc-Tin Brazing Alloy(High-silver solder )
- 5 . Silver-Copper-Zinc-Cadmium Brazing Alloy(High-silver solder)
- 6 . Brass Brazing Alloy

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- 7 . Flux-cored Aluminum Based Brazing Alloy
- 8 . Copper-Aluminum Brazing Alloy
- 9 . Copper Welding Rings And Silver Brazing Ring
- 10 . Capillary tube refrigeration
- 11 . Silver brazing flux powder And Brass brazing flux
- 12 . AWS E1100 Pure Aluminum Welding Wire
- 13 . Aluminum and aluminum alloy welding wire ER5356
- 14 . Aluminum and aluminum alloy welding wire ER4043
- 15 . Aluminum and aluminum alloy welding wire ER4047