

HABCO HP 40

**A DENSE COPPER BASE ALLOY FOR JOINING
AND REBUILDING COPPER AND COPPER BASE WORN PARTS**

FEATURES

HABCO HP 40 is a self-wetting copper base alloy for joining or repairing worn copper parts. The low melting point of this alloy makes it ideal for subassembly work it often replaces silver solder on copper or copper to copper applications. This is one of the quickest ways to make strong, leak-proof joints.

APPLICATIONS

This thin flowing alloy is self-wetting on copper. It is ideal for joints on thin walled tubing and complex copper and copper alloy parts. Excellent for use in rebuilding armatures in electric motor repair. It is also used for air conditioning and refrigeration tubing. When using on copper base alloys, **HABCO FX 850** flux must be used.

TECHNICAL DATA

The area to be overlaid should be cleaned just before applying. Pre-heat the entire area to 600°F (316°C) (on steel, a blue tint will be noticed). Spray a thin layer of powder over the entire area keeping the torch tip approximately 2-3 inches from the work piece. Without spraying any more alloy, position the tip about 3/4 inch to 1 inch above the work piece and wet the alloy out. If a thicker deposit is required, repeat the process.

Tensile Strength: Approx. 42,000 Psi (30 kg/mm²)

Bonding Temperature: Approx. 1185°F (641°C)