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CDA 101 TECHNICAL DATA

NOMINAL COMPOSITION	Copper	99.99% Min
	Silver	0.0025% Max
	Arsenic	0.0025% Max
	Bismuth	0.0001% Max
	Cadmium	0.0001% Max
	Iron	0.001% Max
	Nickel	0.001% Max
	Oxygen	0.0005% Max
	Phosphorus	0.0003% Max
	Lead	0.005% Max
	Sulfur	0.0015% Max
	Antimony	0.0004% Max
	Selenium	0.0003% Max
	Tin	0.0002% Max
Tellurium	0.0002% Max	
Zinc	0.0001% Max	
PHYSICAL PROPERTIES	Color	Copper
	Solidus	1981°F (1083°C)
	Liquidus	1981°F (1083°C)
	Recommended Brazing Temperature	2000-2150°F (1093-1177°C)
	Density (lbs./in³)	0.32
	Specific Gravity	8.94
	Electrical Conductivity (%IACS)	101
Electrical Resistivity (Microhm-cm)	1.71	
USES	CDA 101 is a fluid filler metal used for brazing of ferrous and nickel-based alloys in particular steel, stainless steel and copper-nickel alloys. This alloy is typically used in furnace braze applications without the use of flux.	
BRAZING CHARACTERISTICS	CDA 101 is a free-flowing filler metal that exhibits good wetting characteristics on ferrous and nickel based materials. Maximum strength and joint integrity are obtained where joint clearance falls within the range of 0.000in – 0.001in (0.000-0.025mm) per side.	
PROPERTIES OF BRAZED JOINTS	The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design, metallurgical interaction between the base metal and the filler metal.	
SPECIFICATIONS	CDA 101 alloy conforms to: American Welding Society (AWS) A5.8/A5.8M BVCu-1x, Unified Numbering System (UNS) C10100, AMS 4700E and ASTM B152 C10100	
AVAILABLE FORMS	Wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.	

Individuals requiring further information and Engineering Specification Documents may wish to contact the Engineering Society for Advanced Mobility, Land Sea Air and Space, The Society of Automotive Engineers <http://www.sae.org/> (SAE AMS) or The American Welding Society (AWS) <http://aws.org/>

NOTE:

DISCLAIMER

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