ACR Brazing Rings (BCuP-5)

SPECIAL FEATURES

Fewer Leaks: Brazing rings provide high filler penetration in the joint, reducing the amount of voids and leaks when compared to hand-fed brazing rod.

Repeatable: The brazed joint is visibly complete when the filler protrudes around the full circumference of the outside of the joint. This gives the operator a repeatable visual indicator of a completed brazed joint.

Simple Brazing Process: The brazing ring is inserted inside the joint prior to heating, freeing one of the operator's hands and eliminating the guesswork of how much brazing rod to use.

Reduces Brazing Material: Preformed rings provide the right amount of filler material for each size connection, eliminating guesswork as to how much brazing rod to use - This results in reduced material costs.

Double Fillets: Fillets form on both the inside and outside of the brazed joint, indicating full-depth filler penetration. This results in a consistently high-quality connection as opposed to the questionable penetration depth when hand-feeding brazing rod.

PRODUCT

Brazing Rings create a high quality and repeatable joint while simplifying the brazing process and reducing waste. The correct amount of brazing material is used every time to create reliable joints.

SPECIFICATIONS

Material Composition:

Silver: 15.0% ± 0.5%
Phosphorus: 5.0% ± 0.2%
Copper: Remainder

Size Range: Available for tubing sizes 3/8" to 1-5/8" OD.

Melting Point: 1190 °F

Brazing Temperature Range: 1300 - 1500°F (705 - 815°C)

Flow Point: 1300°F

Standards:
- American Welding Society (AWS) A5.8/A5.8M BCuP-5
- ASME Boiler & Pressure Vessel Code, Sec II-C, SFA-5.8 BCuP-5

⚠ CAUTION

▲ This product contains or produces a chemical known to the State of California to cause cancer and brith defects (or other reproductive harm).

▲ Store at normal room temperature in dry conditions.

▲ Use with proper brazing depths (refer to ASME B16.50 Table 1-3: Dimensions of Braze-Joint Ends), accounting for the depth of the brazing ring.

▲ Use with proper swage IDs per ASME B 16.50.

▲ Use only with ACR copper tubing.

NOTE: Quantities are estimates only. Contractor is responsible for quantities required on project.

Qty.	Product #	Description
	BRG03	BCuP-5 (15% Silver) Brazing Ring for 3/8 OD Copper Tubing
	BRG04	BCuP-5 (15% Silver) Brazing Ring for 1/2 OD Copper Tubing
	BRG05	BCuP-5 (15% Silver) Brazing Ring for 5/8 OD Copper Tubing
	BRG06	BCuP-5 (15% Silver) Brazing Ring for 3/4 OD Copper Tubing
	BRG07	BCuP-5 (15% Silver) Brazing Ring for 7/8 OD Copper Tubing
	BRG09	BCuP-5 (15% Silver) Brazing Ring for 1-1/8 OD Copper Tubing
	BRG11	BCuP-5 (15% Silver) Brazing Ring for 1-3/8 OD Copper Tubing
	BRG13	BCuP-5 (15% Silver) Brazing Ring for 1-5/8 OD Copper Tubing

ACR Brazing Rings (BCuP-5)

Important Installation Notes

GENERAL

1) Refer to Reftekk website (http://www.reftekk.com) for additional information
2) Refer to Reftekk Installation Instructions for additional information
3) Instructional video coming soon
4) Use with sockets formed with Reftekk SwageX swaging expander or conventional factory fittings
5) Use **ONLY** with OD sized tubing
6) Recommended to leak-test with 95/5 (95% nitrogen / 5% hydrogen) during pressure test
7) Ensure the system is properly evacuted prior to charging with refrigerant.
    - For additional information, refer to Reftekk's white pape: "Evacuation of Refrigerant Piping Systems"

PREPERATION

1) Clean male and female portions of joint w/ "Scotch-Brite General Purpose Scouring Pad" prior to assembly
2) Place brazing ring in female socket such that it fully seated at the bottom of the socket
3) Brazing ring should fit snuggly in socket, but should not be loose
4) Insert male tube into socket with full contact with brazing ring

BRAZING

1) Do **NOT** use separate flux. Phosphorus flux is contained in the brazing ring
2) Do **NOT** braze without nitrogen purge
3) Recommended to braze with Oxy-Propane instead of Oxy-Acetlyne
    - For additional information, refer to Reftekk's white pape: "Brazing with Propane and Oxygen"
3) Apply heat to male tube near the joint and to the fitting or swaged joint
4) Flow temperature 1300˚F
5) Joint is complete when brazing filler material is visible at the tube/socket intersection
6) Do **NOT** overheat