

SOPORMETALTM

BRAZING TECNOLOGY SINCE 1985

A INDUCAST TRADEMARK

THE BRAZING FACTORY

ONE STEP AHEAD

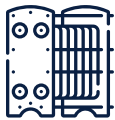
CATALOG

GENERAL PRODUCTS

Brazing technology since 1985

40 YEARS
BRAZING EXCELLENCE

COMPLETE RANGE FOR HVAC-R AND INDUSTRY



HEAT EXCHANGERS
AND HEAT PUMPS



ELECTRICAL
COMPONENTS



HEAT EXCHANGERS
AND HEAT PUMPS



CUTTING TOOLS
(CARBIDE AND HARD METAL)

INDICE

- 2** | About Sopormetal
- 3** | Silver Brazing Alloys
- 4** | Tables / Silver Brazing Alloys
- 5** | Silver Cadmium Alloys
- 6** | Tables / Silver Cadmium Alloys
- 7** | Flux Coated Rods
- 8** | Copper Phosphorus Alloys
- 9** | Tables / Copper Phosphorus Alloys
- 10** | Tables / Copper Phosphorus Alloys
- 11** | Rings and Preforms
- 12** | Aluminum Alloys
- 13** | Brazing Fluxes
- 14** | Tables / Brazing Fluxes

ABOUT SOPORMETAL



WE WORK FOR SINCE 1985 INDUSTRIAL AROUND THE WORLD

SOPORMETAL is a Portuguese brand with over 40 years of experience in the brazing industry, now part of Inducast, Lda. Over four decades, we have built a strong reputation in the development and manufacturing of brazing alloys, with particular expertise in silver and copper-phosphorus alloys, serving customers and partners worldwide. Combining technical expertise, manufacturing capabilities and continuous innovation, SOPORMETAL develops reliable and efficient solutions tailored to the specific requirements of each customer. Quality, innovation and continuous improvement are at the core of our activity. We maintain high standards throughout the entire process, from raw material selection and manufacturing to quality control, technical support and customer service.

SOPORMETAL
THE BRAZING FACTORY.
OVER 40 YEARS OF BRAZING EXCELLENCE.
ONE STEP AHEAD.

Our growth is built on strong relationships with customers, suppliers and partners. We preserve the knowledge and experience accumulated over four decades while continuously investing in new technologies, processes and solutions. With a strong international presence, our industrial and commercial structure provides flexibility, manufacturing capacity and competitive response times across global markets. Our portfolio includes silver alloys, copper-phosphorus alloys, soft solders, special alloys and brazing fluxes, serving industries such as HVAC/R, automotive, electronics, construction, engineering, industrial maintenance, tooling, thermal equipment and aerospace. More than supplying products, we provide brazing solutions, combining experience, technology, quality and close customer support.



PRODUCTS

SILVER BRAZING ALLOYS

This group of alloys has been developed in accordance with current environmental requirements, providing a safe and efficient alternative to traditional cadmium-containing brazing alloys.

These alloys are particularly suitable for low-temperature brazing applications and can be used to join a wide range of materials, including copper, stainless steel, carbon steel, nickel and other metallic alloys.

The resulting joints offer excellent mechanical properties, including high strength, ductility and deformation capability, ensuring reliable and durable connections even in demanding technical applications. Thanks to their high performance and cadmium-free composition, these alloys represent a modern and sustainable solution for brazing processes, fully aligned with evolving environmental legislation and the latest requirements of the industry.



TABLES

SILVER BRAZING ALLOYS

REFERENCE	NORMS				MELTING RANGE °C	WORKING TEMPERATURE °C	CHEMICAL COMPOSITION				
	ISO 17672	EN 1044	DIN 8513	AWS A5.8M/A5.8			Ag%	Cu%	Zn%	Sn%	Others%
SoporGreen 20 T Si	-	Ag 206	L-Ag20	-	690-810	810	20	44	36	-	Si
	Ternary alloy for brazing of steels, malleable cast iron, copper, brass, bronze, hard metals. Suitable for difficult surfacing application of bronze and brass parts, apparatus construction, refrigeration industry, instrument making, etc.										
SoporGreen 25 T	Ag 225	Ag 205	L-Ag25	-	700-790	780	25	40	35	-	-
	Economical solution for brazing steels and copper.										
SoporGreen 25 Sn	Ag 125	Ag 108	L-Ag25Sn	BAG-37	680-760	750	25	40	33	2	-
	Economical solution for cadmium-free alloys.										
SoporGreen 30 T	Ag 230	Ag 204	L-Ag30	BAG-20	680-765	750	30	38	32	-	-
	Economical solution for brazing steels and copper.										
SoporGreen 30 Sn	Ag 130	Ag 107	L-Ag30Sn	-	665-755	740	30	36	32	2	-
	A middle solution for brazing steel and copper. More fluid.										
SoporGreen 34 Sn	Ag 134	Ag 106	L-Ag34Sn	-	630-730	710	34	36	27,5	2,5	-
	For brazing stainless steels, malleable cast iron, copper, brass, bronze, nickel, hard metals and other metals. Applications: precision tools, electrical industry, refrigeration equipment, etc.										
SoporGreen 35 T	Ag 235	-	-	BAG-35	685-755	755	35	32	33	-	-
	Indicated for an intermediate brazing solution.										
SoporGreen 38 Sn	Ag 138	-	-	BAG-34	650-720	720	38	32	28	2	-
	Alloy indicated for brazing steel and similar materials. Economical solution.										
SoporGreen 40 Sn	Ag 140	Ag 105	L-Ag40Sn	BAG-28	650-710	690	40	30	28	2	-
	Brazing alloy developed to join steel and copper alloys. The fluidity of this alloy is reinforced by its tin content.										
SoporGreen 44 T	Ag 244	Ag 203	L-Ag44	-	675-735	730	44	30	26	-	-
	For brazing steel, copper, brass, bronze, nickel. Suitable for food processing industry, breweries, dairies, apparatus construction, instrumentation and precision tools. Suitable for joints subject to temperatures up to 400°C. Colour similar to brass.										
SoporGreen 45 T	Ag 245	-	-	BAG-5	663-745	740	45	30	25	-	-
	Ternary silver alloy with high content of silver.										
SoporGreen 45 Sn	Ag 145	Ag 104	L-Ag45Sn	BAG-36	640-680	670	45	27	25,5	2,5	-
	Brazing alloy with a high percentage of silver, recommended to stainless steel and other metals. Indicated for food manufacture. Economical solution compared with SoporGreen 56 Sn.										
SoporGreen 50 T	Ag 250	-	-	BAG-6	688-774	775	50	34	16	-	-
	Ternary solder with a high percentage of silver.										
SoporGreen 55 Sn	Ag 155	Ag 103	L-Ag55Sn	-	630-660	650	55	21	22	2	-
	For brazing of stainless steel, malleable cast iron, copper, brass, bronze, nickel carbides and other metals. Recommended for medical applications, water piping, pharmaceuticals and food processing industries. When brazing stainless steel, obtains an excellent colour match.										
SoporGreen 56 Sn	Ag 156	Ag 102	L-Ag56Sn	BAG-7	620-655	650	56	22	17	5	-
	Brazing with high silver content for joining stainless steel and other metals. Indicated to braze material is in contact with food manufacture.										
SoporGreen 60 T	-	Ag 202	L-Ag60	-	695-730	710	60	26	14	-	-
	Silver alloy with high capillarity and similar color to silver.										
SoporGreen 65 T	Ag 265	-	-	BAG-9	670-710	710	65	20	15	-	-
	Ternary alloy with high mechanical strength and high content of silver.										
SoporGreen 70 T	Ag 270	-	-	BAG-10	690-740	740	70	20	10	-	-
	Ternary alloy indicated for the jewelry sector.										
SoporGreen 72 Eutetic	Ag 272	Ag 401	L-Ag72	BAG-8	780-780	780	72	28	-	-	-
	Eutectic alloy suitable for furnace vacuum.										
SoporGreen 99,95	-	-	-	BVAg-0	961-961	960	□ 99,95	-	-	-	-
	Pure silver with a high melting point.										

PRODUCTS

SILVER CADMIUM BEARING ALLOYS

Silver-cadmium brazing alloys are particularly suitable for low-temperature brazing applications, offering excellent flow characteristics and reliable performance across a wide range of base materials. These alloys can be used for joining copper, stainless steel, carbon steel, brass, nickel alloys and other metallic materials, including combinations such as steel-to-steel, steel-to-brass and brass-to-copper. Their relatively low brazing temperatures help reduce thermal impact on the components while promoting good joint integrity.

The resulting brazed joints provide high mechanical strength, excellent ductility and good deformation capability, making these alloys especially suitable for demanding and specialised applications. They also provide very good results when brazing nickel-based alloys and ferrous materials. Due to their cadmium content, these alloys must be handled in accordance with applicable health, safety and environmental regulations. Brazing operations should only be carried out in properly ventilated areas using appropriate extraction and personal protective equipment.



TABLES

SILVER CADMIUM BEARING ALLOYS

REFERENCE	NORMS				MELTING RANGE °C	WORKING TEMPERATURE °C	CHEMICAL COMPOSITION				
	ISO 17672	EN 1044	DIN 8513	AWS A5.8M/A5.8			Ag%	Cu%	Zn%	Cd%	Others%
SoporFlow 12	-	-	L-Ag12Cd	-	620-825	800	12	50	31	7	-
	With low content of silver. For brazing steps.										
SoporFlow 17 Si	-	-	-	-	665-760	725	17	40,5	26,5	15,5	Si
	Alloy with low percentage of silver. Recommended for joints with low mechanical resistance.										
SoporFlow 19 Si	-	-	-	-	665-740	720	19	38	24,5	18	Si
	Economical solution. Has high capillarity and is recommended for the industrial refrigeration.										
SoporFlow 20	-	Ag 309	L-Ag20Cd	-	605-765	750	20	40	25	15	-
	Silver brazing alloy developed for refrigeration manufacture and copper pipes for gas installation.										
SoporFlow 23 Si	-	-	-	-	616-735	720	23	34	29	14	Si
	Easy flowing silver alloy. Due to the wide melting range is suitable for the bridging of gaps. The usual applications are the apparatus constructions, copper tubes and for joining dissimilar metals.										
SoporFlow 25	Ag326	Ag 307	L-Ag25Cd	BAG-33	605-720	710	25	30	27,5	17,5	-
	Brazing of steels, malleable cast iron, copper, brass, bronze, nickel and hard metals. It is also recommended for joining dissimilar metals.										
SoporFlow 30	Ag330	Ag 306	L-Ag30Cd	BAG-2a	600-690	680	30	28	21	21	-
	Recommended for the joining of carbon steels, alloyed steels, malleable cast iron, copper, brass, bronze nickel, hard metals and also for joining combinations of these metals. For apparatus constructions, instrument making, precision tools, joining of copper tubing and series manufactures.										
SoporFlow 35 Gm	Ag335	Ag 305	-	-	610-700	700	35	26	21	18	-
	Brazing alloy similar to SoporFlow 40 Cd but with different melting point. Suitable for larger joints.										
SoporFlow 40	Ag340	Ag 304	L-Ag40Cd	BAG-1	595-630	610	40	19	21	20	-
	Brazing of steel and stainless steel, malleable cast iron, copper, brass, bronze, nickel and hard metals. Also for joining dissimilar metals, apparatus construction, instrument making, shipbuilding, electrical industry, precision tools, joining of copper conductors, refrigeration equipment, etc.										
SoporFlow 45 Gm	-	-	L-Ag45Cd	-	620-635	620	45	17	18	20	-
	Joining of steel, stainless steel, malleable cast iron, copper, brass, bronze, nickel, carbides, electrical industry, instrumentation, pipes and refrigeration units.										
SoporFlow 50	Ag350	Ag 301	L-Ag50Cd	BAG-1a	620-640	640	50	15	16	19	-
	Ternary silver alloy with high content of silver.										

PRODUCTS FLUX COATED RODS



Copper-phosphorus brazing alloys are among the most widely used filler metals for joining copper and copper-based materials, particularly in the HVAC/R, refrigeration, air-conditioning, plumbing and heat-exchanger industries.

One of their main advantages is the self-fluxing action of phosphorus when brazing copper-to-copper joints. The phosphorus contained in the alloy acts as a deoxidising agent, eliminating the need for additional flux in many copper-to-copper applications. This simplifies the brazing process, reduces preparation time and helps improve productivity and overall process efficiency.

When brazing copper to brass, bronze or other copper alloys, the use of an appropriate brazing flux may be required to ensure proper wetting, flow and joint quality.



PRODUCTS

COPPER PHOSPHORUS ALLOYS

Copper-phosphorus brazing alloys are among the most widely used filler metals for joining copper and copper-based materials, particularly in the HVAC/R, refrigeration, air-conditioning, plumbing and heat-exchanger industries.

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When brazing copper to brass, bronze or other copper alloys, the use of an appropriate brazing flux may be required to ensure proper wetting, flow and joint quality.

Copper-phosphorus alloys offer excellent fluidity, good capillary action and reliable joint performance. Their melting range and flow characteristics can be adjusted through the combination of phosphorus and silver content, allowing the filler metal to be selected according to the specific application and required brazing conditions.



TABLES COPPER PHOSPHORUS ALLOYS

COPPER PHOSPHORUS ALLOYS WITHOUT SILVER

REFERENCE	NORMS				MELTING RANGE °C	WORKING TEMPERATURE °C	CHEMICAL COMPOSITION		
	ISO 17672	EN 1044	DIN 8513	AWS A5.8M/A5.8			Cu%	P%	Others%
FOSOP 6 S	-	-	-	-	710-890	790	94.4	5.6	-
	Brazing phosphorus alloy with large plasticity.								
FOSOP 6	CuP 179	CP 203	L-CuP6	-	710-890	760	93.8	6.2	-
	Copper-phosphorous alloy with low capillarity.								
FOSOP 7	CuP 180	CP 202	L-CuP7	-	710-820	730	93.0	7.0	-
	Copper-phosphorous alloy with medium fluidity.								
FOSOP 0	CuP 181	-	-	BCuP-2	710-793	730	92.7	7.3	-
	Copper-phosphorous alloy with medium capillarity.								
FOSOP 8	CuP 182	CP 201	L-CuP8	-	710-770	720	92.2	7.8	-
	Copper-phosphorous alloy with high fluidity.								
FOSOP 7 Sn	CuP 386	CP 302	-	-	650-700	700	86.2	6.8	Sn 7.0
	Copper-phosphorous alloy with tin for low temperature.								
FOSOP 6,5 SnSi	CuP 385	-	-	BCuP-9	635-675	670	86.8	6.5	Sn 6.5 / Si 0.21
	Alloy suitable for low working temperatures in copper-brass brazing procedures.								
FOSOP - ADVANCED TECHNOLOGY									
FOSOP 6 ADV	CuP 179	CP 203	L-CuP6	-	710-890	760	93.8	6.2	-
	Copper-phosphorous alloy with low capillarity.								
FOSOP 7 ADV	CuP 180	CP 202	L-CuP7	-	710-820	730	93.0	7.0	-
	Copper-phosphorous alloy with medium capillarity.								
FOSOP 0 ADV	CuP 181	-	-	BCuP-2	710-793	730	92.7	7.3	-
	Copper-phosphorous alloy with medium capillarity.								
FOSOP 8 ADV	CuP 182	CP 201	L-CuP8	-	710-770	720	92.2	7.8	-
	Copper-phosphorous alloy with high fluidity.								

* The Advanced alloys group result from a different manufacturing technology. They are very soft alloys with uniform behavior ensuring stabilized melting baths and without segregation. This technology allows a more stable behavior along the solidification process thereof being a more uniform surface. They support higher thermal melting cycles. These alloys meet all the actual standards in accordance with the specification.

TABLES COPPER PHOSPHORUS ALLOYS

COPPER PHOSPHORUS ALLOYS WITH SILVER

REFERENCE	NORMS				MELTING RANGE °C	WORKING TEMPERATURE °C	CHEMICAL COMPOSITION			
	ISO 17672	EN 1044	DIN 8513	AWS A5.8M/A5.8			Ag%	Cu%	P%	Others%
FOSILVER										
FoSilver 0,4	-	-	-	-	710-740	710	0,4	93,6	6,0	-
	Phosphorous alloy with residual value of silver.									
FoSilver 1	-	-	-	-	645-810	710	1,0	92,5	6,5	-
	Phosphorous alloy with a small percentage of silver.									
FoSilver 2	CuP 279	CP 105	L-Ag2P	-	645-825	740	2,0	91,7	6,3	-
	Suitable to refrigeration equipment. Economical solution.									
FoSilver 2 FF	CuP 280	-	-	BCuP-6	643-788	715	2,0	91,0	7,0	-
	Low cost alloy suitable for brazing copper-copper and copper with copper alloys.									
FoSilver 5	CuP 281	CP 104	L-Ag5P	BCuP-3	645-815	710	5,0	89,0	6,0	-
	Suitable for refrigeration equipment. High density.									
FoSilver 5 FF	-	-	-	-	645-790	710	5,0	88,5	6,5	-
	Intermediate alloy between FoSilver 5 and FoSilver 5 FFF, specially suited for delicate works.									
FoSilver 5 FFF	CuP 282	-	-	BCuP-7	643-771	710	5,0	88,2	6,8	-
	Alloy with a narrow melting range and good fluidity compared with the FoSilver 5.									
FoSilver 6	CuP 283	-	-	BCuP-4	645-725	690	6,0	86,7	7,3	-
	Intermediate temperature alloy suitable for brazing copper-copper and copper with copper alloys.									
FoSilver 6 Ni	CuP 238a	CP 103	-	-	645-725	690	6,0	86,6	7,3	Ni 0,1
	Alloy suitable for use on copper, copper alloys and non-ferrous metals. Slightly more fluid than FoSilver 5.									
FoSilver 15	CuP 284	CP 102	L-Ag15P	BCuP-5	645-800	700	15,0	80,0	5,0	-
	High fluid copper-phosphorous alloy with high silver content. Excellent flowing characteristics.									
FoSilver 18	CuP 286	CP 101	-	-	645-645	650	18,0	74,95	7,05	-
	Alloy particularly suitable for the cooling industry requiring an extensive use of Cu/Cu.									
FOSILVER - ADVANCED TECHNOLOGY										
FoSilver 2 ADV	CuP 279	CP 105	L-Ag2P	-	645-825	740	2,0	91,7	6,3	-
	Suitable to refrigeration equipment. Economical solution.									
FoSilver 2 FF ADV	CuP 280	-	-	BCuP-6	643-788	715	2,0	91,0	7,0	-
	Low cost alloy suitable for brazing copper-copper and copper with copper alloys.									
FoSilver 5 ADV	CuP 281	CP 104	L-Ag5P	BCuP-3	645-815	710	5,0	89,0	6,0	-
	Suitable for refrigeration equipment. High density.									
FoSilver 5 FF ADV	-	-	-	-	645-790	710	5,0	88,5	6,5	-
	Intermediate alloy between FoSilver 5 and FoSilver 5 FFF, specially suited for delicate works.									
FoSilver 5 FFF ADV	CuP 282	-	-	BCuP-7	643-771	710	5,0	88,2	6,8	-
	Alloy with a narrow melting range and good fluidity compared with the FoSilver 5.									
FoSilver 15 ADV	CuP 284	CP 102	L-Ag15P	BCuP-5	645-800	700	15,0	80,0	5,0	-
	High fluid copper-phosphorous alloy with high silver content. Excellent flowing characteristics.									
FoSilver 18 ADV	CuP 286	CP 101	-	-	645-645	650	18,0	74,95	7,05	-
	Alloy particularly suitable for the cooling industry requiring an extensive use of Cu/Cu.									

* The Advanced alloys group result from a different manufacturing technology. They are very soft alloys with uniform behavior ensuring stabilized melting baths and without segregation. This technology allows a more stable behavior along the solidification process thereof being a more uniform surface. They support higher thermal melting cycles. These alloys meet all the actual standards in accordance with the specification.

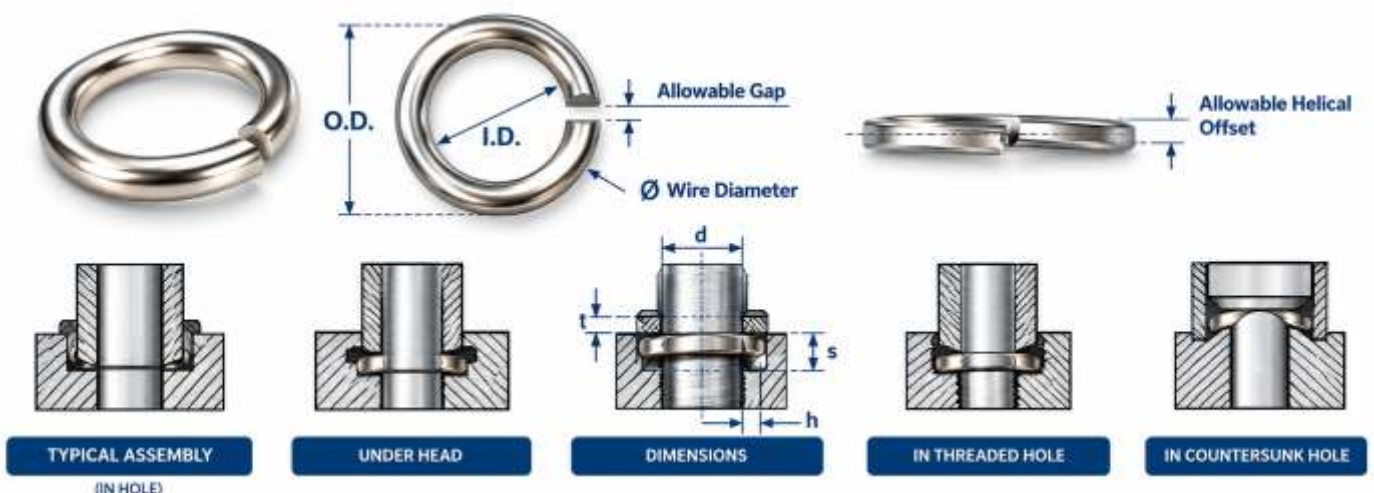
PRODUCTS RINGS AND PREFORMS



Brazing rings and preforms can be manufactured in a wide range of dimensions, geometries and wire diameters, using different brazing alloys to meet the specific requirements of each application.

The correct selection of a ring or preform should take into account the joint design, dimensional tolerances, required alloy volume, brazing process and whether the component will be positioned manually or through an automated feeding system.

Rings and preforms have become essential components in modern industrial production, particularly in high-volume and automated brazing operations. By providing a precise and repeatable amount of filler metal at each joint, they help improve process consistency, increase productivity, reduce material waste and labour costs, and enhance overall manufacturing efficiency.

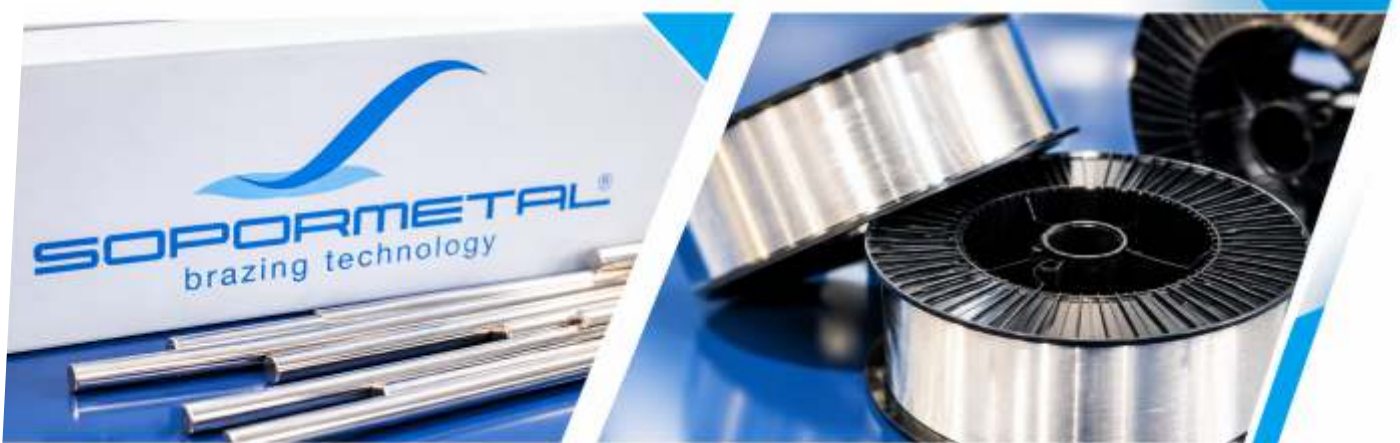


PRODUCTS ALUMINIUM ALLOYS

SOPORMETAL aluminium consumables are developed to provide consistent quality, excellent process stability and high productivity across a wide range of industrial applications.

Our aluminium wires and rods are suitable for different welding and brazing processes, including MIG, TIG, GMAW and GTAW, and are manufactured to ensure reliable feeding, controlled performance and repeatable results.

We offer a broad range of aluminium alloy compositions and can also develop specific solutions according to customer requirements, applications and production conditions.



REFERENCE	NORMS					MELTING RANGE °C	CHEMICAL COMPOSITION							
	DIN	AA 4245	A.M.S.	ANSI Z 49.1	AWS		Si%	Mn%	Mg%	Cr%	Zn%	Ti%	Others %	Al%
SoporAl 99,8	3.0286	-	-	-	1050	647-658	0.15max.	-	-	-	0.06max.	0.03max.	-	bal
SoporAl 99,5	3.0259	-	-	-	1050	647-658	0.03max.	-	-	-	0.07	0.05	-	bal
SoporAl 99,5Ti	3.0805	-	-	-	1450	647-658	0.30max.	-	-	-	0.07	0.15	-	bal
SoporAl Mg3	3.3536	-	-	-	5154	580-642	0.25max.	0.3	3	-	0.2	0.15	-	bal
SoporAl Mg5	3.3556	-	-	-	-	562-630	0.25max.	0.3	5	-	0.2	0.15max.	-	bal
SoporAl Mg4,5Mn	3.3548	-	-	-	5183	574-638	0.25max.	0.8	4.5	0.2	0.25	0.15max.	-	bal
SoporAl Mg4,5MnZr	3.3546	-	-	-	5087	574-638	0.25max.	0.7	4.5	0.2	0.25	0.15max.	Zr-0.2	bal
SoporAl Si5	3.2245	-	-	-	4043	573-625	5	0.20max.	0.10max.	-	0.2	0.15max.	-	bal
SoporAl Si5 Flux	3.2245	-	-	-	4043	572-625	5	0.20max.	0.10max.	-	0.2	0.15max.	-	bal
SoporAl 4245	-	AA4245	-	-	-	516-560	10	-	-	-	10	-	Cu-4	bal
SoporAl 4145	-	AA4245	4184	-	BAISi3	521-585	10	-	-	-	-	-	Cu-4	bal
SoporAl Si12	3.2585	AA4047	4185	-	BAISi4	573-585	12	0.30max.	0.05max.	-	0.1	0.15max.	-	bal
SoporAl Si12 Flux	3.2585	-	-	-	4047	573-585	12	0.30max.	0.05max.	-	0.1	0.15max.	-	bal
SoporAl Zn2	-	-	-	D.Sheet AL 802	-	377-385	-	-	-	-	2	-	-	bal
SoporAl Zn5	-	-	-	D.Sheet AL 802	-	380-390	-	-	-	-	5	-	-	bal
SoporAl	-	-	-	D.Sheet AL 802	-	482-537	-	-	-	-	22	-	-	bal

PRODUCTS BRAZING FLUXES



Our brazing fluxes have been developed to meet the latest environmental requirements, including low-borax formulations, while complying with the demanding performance standards required by today's brazing industry.

Specially formulated to ensure a clean, controlled and reliable brazing process, SOPORMETAL fluxes provide four essential functions:

Protective effect – helps protect the joint area from oxidation during heating.

Agglomerating effect – captures and binds oxides formed during the heating and melting process.

Cleaning effect – removes surface oxides and contaminants, improving filler metal flow throughout the joint.

Capillary effect – enhances wetting and capillary action, allowing the molten brazing alloy to flow uniformly and achieve complete joint coverage.

Thanks to their carefully engineered formulations, our fluxes provide excellent wetting, improved alloy flow, cleaner joints and consistent brazing performance, offering significant advantages over conventional fluxes.

Each flux is specifically developed for a defined application, base material, brazing alloy and working temperature range, ensuring optimum performance across a wide variety of industrial brazing processes.

SOPORMETAL Brazing Fluxes – engineered for cleaner joints, better flow and reliable brazing performance.



TABLES BRAZING FLUXES

LOW TEMPERATURE FLUXES

LOW TEMPERATURE	STATUS	MELTING RANGE °C	ACTIVITY	FLUIDITY	CAPILLARITY	LIFE	NORMS	
							EN 1045	DIN 8511
SOPOR-FLO	Powder/Paste	450-800	good	good	very good	good	FH 10	F-SH 1
SOPOR-FLO ECO	Powder	550-800	good	good	very good	good	FH 10	F-SH 1
SOPOR-FLO 500	Powder/Paste	400-750	medium	excellent	excellent	good	FH 10	F-SH 1
SOPOR-FLO 550	Powder/Paste	450-800	medium	excellent	good	good	FH 10	F-SH 1
SOPOR-GREEN	Powder/Paste	450-800	good	good	very good	good	-	-

BRAZING CARBIDES

This are fluxes with specific characteristics for an effective wettable carbide characteristic and also sintered alloys. They present particular characteristic that eases and increase the breaking load of the used alloys increasing the quality of the brazed joints. They are particularly indicated for induction processes, diamond tools and in tungsten industry.

BRAZING CARBIDES	STATUS	MELTING RANGE °C	ACTIVITY	FLUIDITY	CAPILLARITY	LIFE	NORMS	
							EN 1045	DIN 8511
SOPOR-SPECIAL HD	Paste	750-1050	-	-	-	-	FH 20	-

MEDIUM TEMPERATURES FLUXES

MEDIUM TEMPERATURE	STATUS	MELTING RANGE °C	ACTIVITY	FLUIDITY	CAPILLARITY	LIFE	NORMS	
							EN 1045	DIN 8511
SOPOR-FLO 780	Powder/Paste	500-850	good	very good	good	very good	FH 10	F-SH 1

HIGHT TEMPERATURE FLUXES

The high temperature fluxes have particularly high lifetime indicated for high temperatures brazing. They present an elevated lifetime period, supporting elevated brazing thermic cycles such as bronze and brass alloys in high temperatures and also hard brazing.

HIGH TEMPERATURE	STATUS	MELTING RANGE °C	ACTIVITY	FLUIDITY	CAPILLARITY	LIFE	NORMS	
							EN 1045	DIN 8511
SOPOR-BRONZE	Powder/Paste	700-950	good	very good	good	excellent	FH 20	-
SOPOR-FLO 740	Powder/Paste	500-850	very good	good	good	very good	FH 10	F-SH 1
SOPOR-FLO 755	Powder/Paste	600-900	excellent	good	good	excellent	FH 10	F-SH 1/2
SOPOR-FLO 850	Powder/Paste	750-1000	good	good	good	excellent	FH 12	F-SH 1/2
SOPOR-FLO 855	Powder	750-900	good	very good	good	excellent	FH 10	F-SH 1/2
SOPOR-FLO 1125	Powder	700-1200	good	good	good	very good	-	-

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