

Working Temperatures & Pressures

Flowflex End Feed fittings can be assembled using a variety of soft or hard solders (brazing alloy). Their working temperatures and pressures vary according to which solder has been used. When correctly assembled with copper tube to BS EN 1057, the applicable temperatures and pressures are indicated in the table below.

Typical examples of soldering alloys		Max Temp (1) °C	Max Pressure for nominal diameters (1) (2) BAR	
			From 6mm up to 34mm	Over 34mm up to 54mm
I	Lead/tin 50/50% or 60/40%	30	16	16
		65	10	10
		110	6	6
I II	Tin/silver 95/5% Tin/Copper Cu 3% Max 0.4% mn. Remainder Sn	30	25	25
		65	25	16
		110	16	10

(1) For use in applications outside the scope of this table, the approval of the manufacturer should be obtained.

(2) Intermediate pressure ratings shall be obtained by interpolation.

NOTE Soldering alloys with lead and brazing alloys with cadmium are not permitted in installations for water for human consumption.