



TECHNICAL SPECIFICATION SHEET

HARRIS PRODUCTS GROUP
4501 QUALITY PLACE
MASON, OHIO 45040
TEL. (513) 754-2000
FAX, (513) 754-8778
www.harrisproductsgroup.com

HARRIS PHOSON PLUS[®] BRAZING FILLER METAL

ISO 9001
Cert. No. 31598

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS (INFRARED RADIATION) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheet (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

STATEMENT OF LIABILITY — DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. Harris Products Group. and its affiliates shall have no liability in respect thereof.

NOMINAL CHEMICAL COMPOSITION:

Silver	14.8 %
Phosphorus	7.3 %
Copper	Balance
Other Totals	.15 %

PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)
Liquidus	1193 -1196°F (645-647°C)
Color	Bright Shiny Copper

Page 1 of 2

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

Additional information available at our web site:

www.jwharris.com

02/08 MK



HARRIS PRODUCTS GROUP
4501 QUALITY PLACE
MASON, OHIO 45040
TEL. (513) 754-2000
FAX, (513) 754-8778
www.harrisproductsgroup.com

TECHNICAL
SPECIFICATION
SHEET

HARRIS PHOSON PLUS® BRAZING FILLER METAL

BRAZING PROPERTIES:

This alloy with a melting range of 1190°-1196°F (645-647°C) is very close to the ternary eutectic composition; designed originally for repair of leaks where it can be fixed without adversely affecting adjacent joints. Also, at brazing temperatures below 1220° (660°C), this greatly reduces oxide build-up around the joint area, as well as lessening the annealment of the base metals. Its extremely low brazing temperature and high fluidity has expanded use in many applications where heat is a critical consideration. In properly designed joints, Phoson+ assures strong reliable brazements with speed and efficiency on all copper, brass, and bronze applications.

AVAILABLE FORMS:

Standard wire diameters, Preformed rings

SPECIFICATION COMPLIANCE:

Harris Internal

RECOMMENDED FLUX:

No flux required on copper

Stay Silv white or black brazing flux with Brasses

Harris Products Group	Fax	513-754-8778
4501 Quality Place	Tel.	513-754-2000
Mason, Ohio 45040		800-733-4533