



## TECHNICAL INFORMATION SHEET

### HARRIS 17 BRAZING FLUX

#### DESCRIPTION:

Harris 17 flux is an all-purpose paste flux for use with bronze alloys (Harris 15) and nickel silver alloys (Harris 17 or 170). This highly active flux can be used in help in the brazing process for steel, cast irons and copper base alloys. Residues may be removed with a hot water rinse leaving a bright, clean, and strong porosity free brazed joint.

#### Nominal Composition

Boric Acid  
Borax

#### APPLICATION:

Clean dirt, oil, or other residue from parts prior to flux application. Harris 17 flux should be brushed on the joint surfaces and adjacent areas prior to heating. If flux becomes dry incrementally add small amounts of water to form a smooth paste.

#### FLUX REMOVAL:

Post braze flux residue should be removed to avoid potential corrosion. A hot water wash and brushing with a rag or non-woven abrasive pad, (e.g. Scotch-Brite™), is often sufficient. Additional measures include mechanical cleaning with a wire brush, steam jet, or abrasive blasting media such as grit, soda, or dry ice.

Production post-braze cleaning can also be accomplished with proprietary chemical formulas such as Bernite® 45 available from Harris Products Group. This approach is suitable where parts lend themselves to a water bath/tank immersion.

#### ACTIVITY RANGE:

1400° - 2200°(760°-1204°)

#### AVAILABLE CONTAINERS:

8 oz. containers

#### SPECIFICATION COMPLIANCE:

AWS A5.31 CLASS FB3-D

#### SAFETY INFORMATION:

**WARNING: CONTAINS FLUORIDES.**  
**PROTECT YOURSELF AND OTHERS.** Read and understand this information.

**BURNS EYS AND SKIN. CAN BE FATAL IF SWALLOWED**  
**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 Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, 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, 8669 Doral Blvd., Doral, Florida 33166; 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. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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