



Technical Specification Sheet

HARRIS LAg18P BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION:

Silver	18.00 %
Phosphorus	7.30%
Copper	Balance

PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)	Brazing Temperature Range	1190°-1250°F (643°-677°C)
Liquidus	1199°F (648°C)		
Density (g/cm ³)	8.40		
Conductivity (%IACS)	5.90		
Resistivity (microhm-cm)	29.40		

BRAZING PROPERTIES:

This is a ternary eutectic alloy formulated for joining copper to copper and copper to brass where close joint tolerance can be maintained, and a low temperature alloy is desired. The recommended joint clearance is .001"-.003".

AVAILABLE FORMS:

Standard wire diameters, preformed rings

SPECIFICATION COMPLIANCE:

DIN EN 1044 CP101

RECOMMENDED FLUX:

No flux is required on copper

Use Stay-Silv white or black brazing flux with brasses

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 Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of the 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 ANSI 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*, are published by the U.S. Government Printing Office, 732 North Capitol Street NW, Washington, DC 20401.

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