



T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

TECHNICAL SPECIFICATION SHEET

HARRIS LAg5PA BRAZING FILLER METAL

ISO 9001
Cert. No. 31598

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.

NOMINAL CHEMICAL COMPOSITION:

Silver	4.5-4.7%
Phosphorus	6.27%
Copper	Balance
Other Totals	.15%

PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)
Liquidus	1460-1470°F (793-799°C)
Color	Bright Shiny Copper

BRAZING PROPERTIES:

An economical brazing filler metal, designed with a broader melting range than the "0" alloys for joining copper to copper and copper to brasses. This alloy is very ductile, and has a wide plastic range suitable for joining loose connections. However, at brazing temperature this alloy is quite fluid and suitable for tight fit ups as well. Recommended joint clearance is .002" - .005".

AVAILABLE FORMS:

Standard wire diameters, Preformed rings

SPECIFICATION COMPLIANCE:

The Harris Products Group, BS 1845 Class CP4, Din 8513 Class Lag 5P

RECOMMENDED FLUX:

No flux required on copper
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.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- 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 fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.

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.harrisproductsgroup.com

3/08 MK



- 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.

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.harrisproductsgroup.com

3/08 MK