



## TECHNICAL INFORMATION SHEET

### SAFETY SILV® 63T BRAZING FILLER METAL

#### NOMINAL CHEMICAL COMPOSITION%:

Silver	62.0 – 64.0
Copper	27.5 – 29.5
Nickel	2.0 – 3.0
Tin	5.0-7.0
Other (Total)	0.15

#### TYPICAL PHYSICAL PROPERTIES:

Solidus	1275°F (691°C)
Liquidus	1475°F (802°C)
Brazing Range	1475°F (800° C) – 1650°F (900°C)
Density	5.22 (t.o./cu.in.).

#### BRAZING PROPERTIES:

Safety Silv 63T is a zinc free brazing alloy typically used to braze stainless steel. It is primarily used in atmosphere or vacuum furnace brazing as the alloy is free of zinc and cadmium. This alloy was developed for use in brazing 400 series, (nickel-free), stainless steels to avoid interface corrosion in salt spray, moisture and chlorine solutions.

#### AVAILABLE FORMS

Standard wire diameters and preform rings

#### RECOMMENDED FLUX:

Recommended for furnace brazing. If torch brazing is employed Stay-Silv® white flux is suitable for many applications. Stay-Silv® black brazing flux can also be used. Care should be taken if the brazed assembly is exposed to moisture and all flux residues should be thoroughly removed. Harris ECO SMART® boric acid free flux, (powder or paste), is an alternate choice to promote sound brazed assemblies and comply with European REACH requirements.

#### SPECIFICATION COMPLIANCE:

AWS A5.8, ASME SFA 5.8 Class BAg 21, AMS 4774  
ISO 17672 Ag 463

#### SAFETY INFORMATION:

**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, Safety Data Sheets (SDS), 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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