



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
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TECHNICAL SPECIFICATION SHEET

ISO 9001
Cert. No. 31598

HARRIS LCuP6 BRAZING FILLER METAL

STATEMENT OF LIABILITY- DISCLAIMER

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NOMINAL CHEMICAL COMPOSITION:

Phosphorus 6.50 %
Copper Remainder
Other Totals .15 % max.

PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)	Specific Gravity	8.11
Liquidus	1545-1549°F (841-843°C)	Elongation in 2"	32 %
Brazing Temperature Range	1350-1550°F (732-843°C)		

BRAZING PROPERTIES:

This is an economical filler metal designed for joining of copper, brass, and bronze. When joining brass or bronze, a chemical flux, such as Stay-Silv[®] white, should be employed. This is a sluggish alloy useful in applications where joint tolerance cannot be maintained. Recommended joint clearance is .002"-.006".

AVAILABLE FORMS:

Standard wire diameters, Preformed rings

SPECIFICATION COMPLIANCE:

DIN 8513, Part 1 Class LCuP-6

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 (MSDS), 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.
- 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.

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