



TECHNICAL INFORMATION SHEET

SAFETY SILV® 54N BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION %:

Silver	53.0 – 55.0
Copper	39.0 – 41.0
Zinc	4.0 – 6.0
Nickel	0.5-1.5
Other (Total)	0.15

TYPICAL PHYSICAL PROPERTIES:

Solidus	1325°F (718°C)
Liquidus	1575°F (857°C)
Brazing Range	1575°F- 1775°F (860°C -970°C)
Electrical Conductivity	49.3 (%IACS)
Density	5.05 (T.O./cu.in.).

BRAZING PROPERTIES:

A cadmium-free braze alloy with a fairly long melting range. The reduced zinc content makes it suitable for furnace brazing applications, often used to braze stainless steel. When oxy-fuel brazing with this filler metal it should be rapidly heated through its melting range to avoid liquation.

AVAILABLE FORMS

Standard wire diameters,

RECOMMENDED FLUX:

Harris Stay-Silv® black brazing flux is required with Safety Silv 54N due to the metal is higher melting point. Harris ECO SMART® boric acid free flux, high temperature flux,(powder or paste), is an excellent choice to promote sound brazed assemblies and comply with European REACH requirements.

SPECIFICATION COMPLIANCE:

ANSI/AWS A5.8 BAg-13, ASME SFA 5.8 BAg-13, AMS 4772

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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